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Mazdoor Kisan Shakti Sangathan

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“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6173-1 (1992): Screwing Taps - Dimensions and Tolerances on Threaded Portion, Part 1: For ISO Metric Screw Threads [PGD 32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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IS 6173 (Part 1) : 1992
(Superseding IS 9169 : 1979)
(Reaffirmed 1997)
Edition 2.1
(1996-01)

भारतीय मानक
पेंचवाली चूड़ियाँ काटने के औजार —
चूड़ीदार भाग के लिए आयाम और छूट
भाग 1 आई एस ओ मीटरी पेंच वाली चूड़ियों के लिए
(पहला पुनरीक्षण)

Indian Standard

**SCREWING TAPS — DIMENSIONS AND
TOLERANCES ON THREADED PORTION**

PART 1 FOR ISO METRIC SCREW THREADS

(First Revision)

(Incorporating Amendment No. 1)

UDC 621.993 : 621.882.082.1 : 006-78

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Price Group 10

FOREWORD

This Indian Standard (Part 1) (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Thread Cutting Taps and Dies Sectional Committee had been approved by the Production Engineering Division Council.

This standard was first published as IS 6173 in 1971. In this revision it has been thoroughly revised and made into two parts, first part covering requirements of ISO Metric Screw Threads and second part covering requirements of Pipe Threads.

The major changes are as given below:

- a) This standard supersedes IS 9169 : 1979 'Dimensions for thread cutting elements for hand taps and machine taps — Serial', the contents of it has been covered in Annex A, so that correlation becomes easier.
- b) The standard has been extended to cover tolerances and dimensions of thread profiles of serial screwing taps of all classes with coarse pitch threads sizes from M1 to M68 and with fine pitch from M1 to M100 with all the possible diameter pitch combination of IS 4218 (Part 2) : 1976 'ISO metric screw threads: Part 2 Diameter pitch combinations (*first revision*)'. The repetition of limits and tolerance for screwing taps in product standards have been deleted.
- c) The tolerance for half Flank angle and Pitch error has been changed and adopted the values from ISO 2857 : 1973.

Considerable assistance has been derived from ISO 2857 : 1973 'Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches — Manufacturing tolerance on threaded portion', issued by the International Organization for Standardization (ISO).

This edition 2.1 incorporates Amendment No. 1 (January 1996). Side bar indicates modification of the text as the result of incorporation of the amendment.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

SCREWING TAPS — DIMENSIONS AND TOLERANCES ON THREADED PORTION

PART 1 FOR ISO METRIC SCREW THREADS

(First Revision)

1 SCOPE

This standard covers dimensions and tolerances on threaded portion of screwing taps for ISO metric screw threads with coarse and fine pitches for serial and non-serial screwing taps with 4H, 6H, 7H ground threads and 7H cut thread classes.

2 REFERENCES

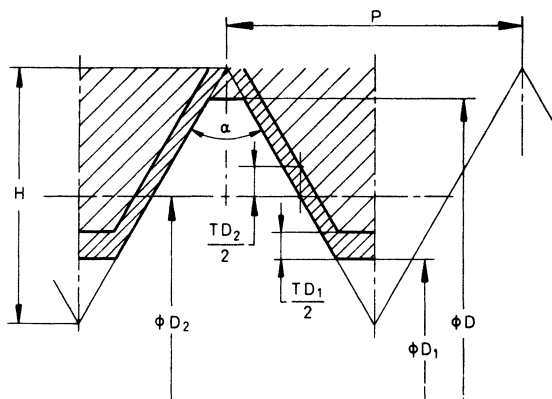
The following Indian Standards are necessary adjuncts to this standard:

<i>IS No.</i>	<i>Title</i>
4218 (Part 2) : 1976	ISO metric screw threads: Part 2 Diameter pitch combinations (first revision)
4218 (Part 4) : 1976	ISO metric screw threads: Part 4 Tolerancing system (first revision)
6171 : 1992	Screwing taps — Technical supply conditions

3 BASIC DATA

3.1 Thread Profile of Nuts

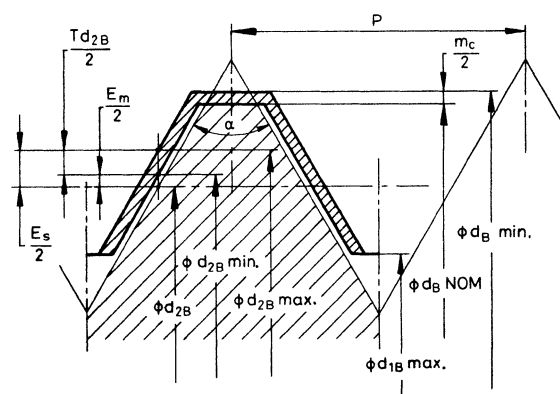
Thread profile of threaded hole with zero minimum clearance on the pitch diameter (that is, with tolerance position *H*).



<i>D</i> = basic major diameter or nominal diameter	<i>H</i> = height of the fundamental triangle
<i>D</i> ₁ = basic minor diameter	α = flank angle of the thread
<i>D</i> ₂ = basic pitch diameter	<i>TD</i> ₁ = minor diameter tolerance
<i>P</i> = pitch of the thread	<i>TD</i> ₂ = pitch diameter tolerance

3.2 Thread Profile of Screwing Taps

Thread profile of screwing taps for tapping threaded hole with zero minimum clearance on the pitch diameter (that is, with tolerance position *H*).



<i>d</i> _{NOM}	= nominal major diameter
<i>d</i> _{Min}	= minimum major diameter
<i>a</i> _{2B}	= basic pitch diameter
<i>d</i> _{2B Min}	= minimum pitch diameter
<i>d</i> _{2B Max}	= maximum pitch diameter
<i>d</i> _{1B Max}	= maximum minor diameter
<i>p</i>	= pitch of the thread
<i>m</i> _c	= minimum clearance (allowance for wear on major diameter)
<i>E</i> _s	= upper deviation of pitch diameter
<i>E</i> _m	= lower deviation of pitch diameter
<i>Td</i> _{2B}	= tolerance on pitch diameter

4 TOLERANCE CLASSES OF SCREWING TAPS

4.1 Ground Thread Screwing Taps

Three classes of screwing tap tolerances, that is, 4H, 6H and 7H shall be used for the various classes of nut threads as given below:

Class 4H is valid for tapping nut threads: 4H and 5H

Class 6H is valid for tapping nut threads: 6H and also 4G and 5G, and

Class 7H is valid for tapping nut threads: 7H, 8H and also 6G.

4.2 Cut Thread Screwing Taps

One class of tap tolerance, that is, 7H shall be used for the production of the class of tapping 7H and 8H.

IS 6173 (Part 1) : 1992

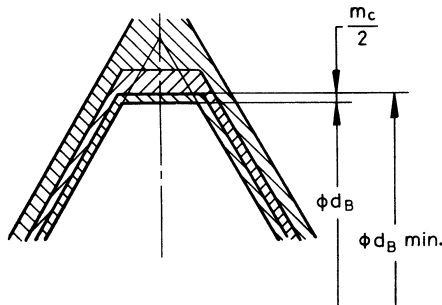
4.3 Since the accuracy of the tapping depends on the material to be tapped, the tapping attachment, the cutting speed, the lubricant, the condition of the machine tool, etc, the users are recommended to select the class of tap consistent with the class of nut thread required. Screwing taps in general shall produce tapped threads to the tolerances specified above.

4.4 In case of non-serial screwing taps the thread profile dimensions are same as that of finisher screwing tap thread dimensions, except for front chamfer (see 6.6 of IS 6171 : 1992 for details of chamfer angle and length).

5 SCREWING TAP THREAD ELEMENTS

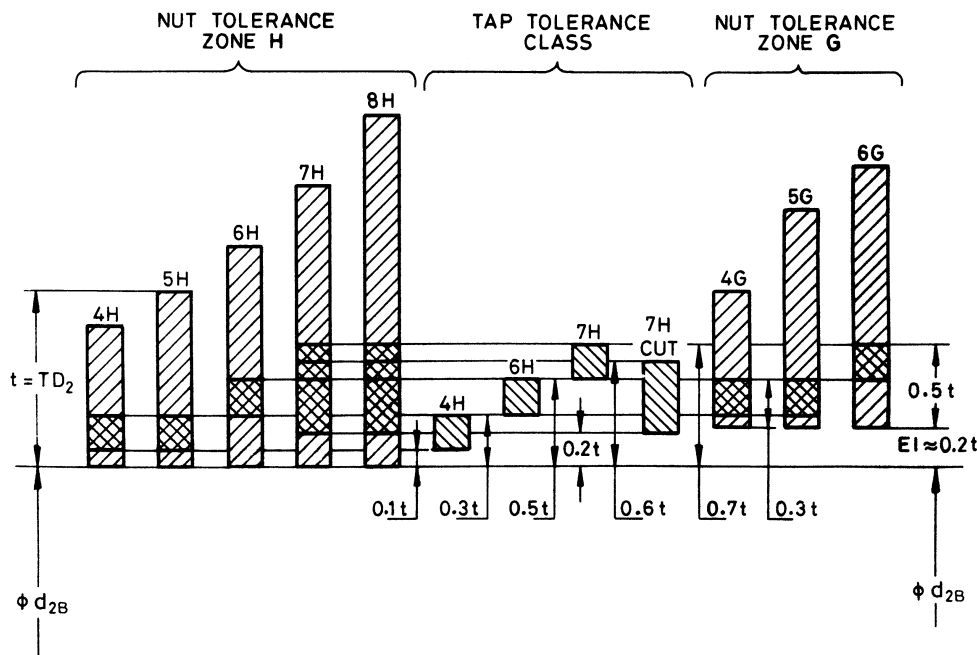
5.1 Major Diameter d_B

To compensate for the wear on tap, the minimum major diameter d_B Min is equal to the nominal diameter D of Nut thread plus deviation m_c . The maximum diameter of d_B has not been specified and is left to the discretion of the manufacturer.



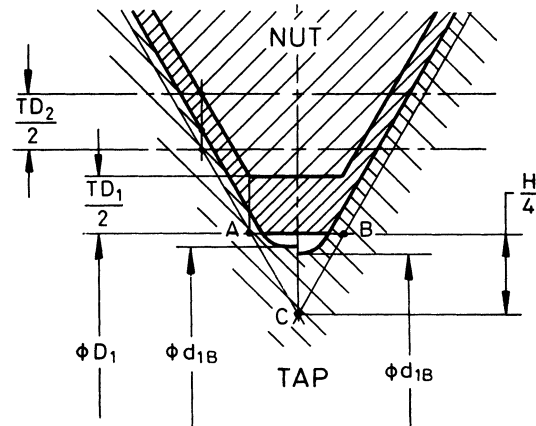
5.2 Pitch Diameter d_{2B}

The figure given below shows the comparison between position of tolerance zones for nut thread and screwing tap threads.



5.3 Minor Diameter d_{1B}

No tolerance has provided on this diameter. However, the root of thread shall lie within triangle ABC and the profile of the roots shall blend with the flanks.



5.4 The formulae for calculating thread profile dimensions for different classes of Rougher, Intermediate and Finisher screwing taps of Serial taps are covered in Table 1.

5.5 The formulae for calculating the thread profile dimensions for Rougher, Intermediate and Finisher screwing taps of serial screwing taps are given in Table 2.

Table 1 Formulae for Calculating Thread Profile Dimensions for Different Classes of Screwing Taps
(Clause 5.4)

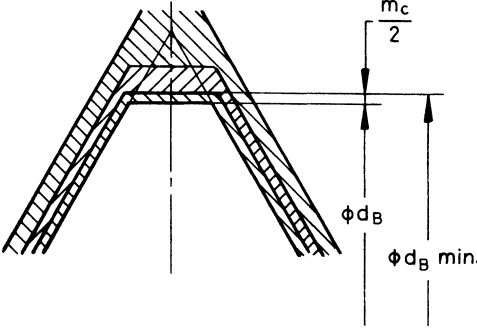
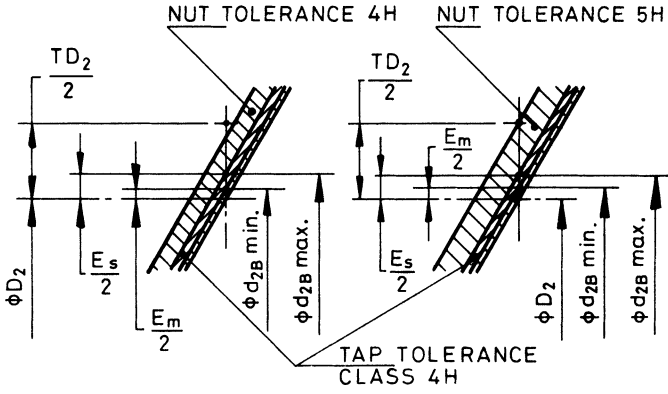
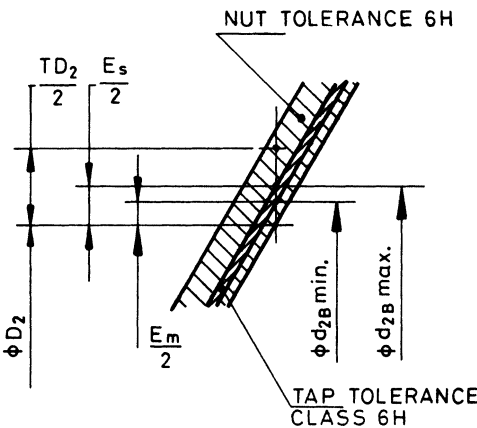
Class of Taps	Tolerance Zone	Formula
		Tolerances on Major Diameter of Tap d_B
All classes		$m_c = 0.4 t^{(1)}$ $d_B \text{ Min} = d_B + m_c$
		Tolerances on Pitch Diameter of Tap d_{2B}
4H Ground		$E_m = 0.1 t$ $E_s = 0.3 t$ $d_{2B} \text{ Min} = D_2 + E_m$ $d_{2B} \text{ Max} = D_2 + E_s$
6H Ground		$E_m = 0.3 t$ $E_s = 0.5 t$ $d_{2B} \text{ Min} = D_2 + E_m$ $d_{2B} \text{ Max} = D_2 + E_s$

Table 1 (Concluded)

Class of Taps	Tolerance Zone	Formula
7H Ground		$E_m = 0.5 t$ $E_s = 0.7 t$ $d_{2B} \text{ Min} = D_2 + E_m$ $d_{2B} \text{ Max} = D_2 + E_s$
7H Cut		$E_m = 0.2 t$ $E_s = 0.6 t$ $d_{2B} \text{ Min} = D_2 + E_m$ $d_{2B} \text{ Max} = D_2 + E_s$

¹⁾The value of t is equal to tolerance on nut pitch diameter of grade 5 T_{D_2} according to IS 4218 (Part 4) : 1976.

Table 2 Formula for Calculating Thread Profile Dimensions for Serial Screwing Taps (Clause 5.5)

No. of Taps in a Set	Type	Major Diameter Min	Pitch Diameter	
			Min	Max
3	Rougher	$d_B \text{ Min} - 0.75 P$	$d_{2B} \text{ Min} - 0.25 P$	$d_{2B} \text{ Max} - 0.25 P$
	Intermediate	$d_B \text{ Min} - 0.35 P$	$d_{2B} \text{ Min} - 0.08 P$	$d_{2B} \text{ Max} - 0.08 P$
	Finisher	$d_B \text{ Min}$	$d_{2B} \text{ Min}$	$d_{2B} \text{ Max}$
2	Rougher	$d_B \text{ Min} - 0.45 P$	$d_{2B} \text{ Min} - 0.12 P$	$d_{2B} \text{ Max} - 0.12 P$
	Finisher	$d_B \text{ Min}$	$d_{2B} \text{ Min}$	$d_{2B} \text{ Max}$

where

$d_B \text{ Min}$ = minimum major diameter of finisher tap,
 $d_{2B} \text{ Min}$ = minimum pitch diameter of finisher tap,

$d_{2B} \text{ Max}$ = maximum pitch diameter of finisher tap,
 P = pitch of the tap threads.

6 THREAD PROFILE DIMENSIONS

6.1 The calculated values of thread profile dimensions for screwing taps for sizes M1 to M68 with coarse pitches and M1 to M100 fine pitches with all the diameter pitch combinations of threads covered in IS 4218 (Part 2) : 1976 in this range are covered in Annex A.

6.2 Tolerances on Half Flank Angle $\alpha/2$

In order to exercise control on the symmetry of the thread as well as the total angle of the thread, the tolerances given in Table 3 for angles are to be regarded as the maximum permissible sum of the errors in the two half flank angles of the screwing tap thread, disregarding their signs.

6.3 Tolerances on Pitch

The limits of tolerance on the pitch shall be as shown in Table 4, which also shows length over which the measurement shall be made, expressed in number of pitches.

6.4 The tolerances on the other elements of the screwing tap shall be according to IS 6171 : 1992.

Table 3 Tolerances on Half Flank Angle $\alpha/2$
(Clause 6.2)

Pitch Range in mm		Tolerances on Half Flank Angle $\alpha/2$ in minutes
Over	Up to and including	
—	0.25	± 70
0.25	0.4	± 50
0.4	0.6	± 35
0.6	0.8	± 30
0.8	1.5	± 25
1.5	3	± 20
3	6	± 15

Table 4 Tolerances on Pitch
(Clause 6.3)

Pitch mm	Measuring Length in Number of Pitches	Limits of Tolerance in Micrometer
0.25	12	± 8
0.3		
0.4		
0.45		
0.5		
0.6	9	± 8
0.7		
0.75		
0.8		
1		
1.25	7	± 8
1.5		
1.75		
2.0		
2.5		
3.0		
3.5		
4.0		
4.5		
5.0		
5.5		
6.0	± 18	

ANNEX A

(Clause 6.1)

DIMENSIONS FOR THREAD PROFILES

Dimensions for thread profiles are covered as given below:

A-1 Dimensions for ISO metric coarse pitch thread of tolerance class 4H are given in Table 5.

A-2 Dimensions for ISO metric coarse pitch thread of tolerance class 6H are given in Table 6.

A-3 Dimensions for ISO metric coarse pitch thread of tolerance class 7H are given in Table 7.

A-4 Dimensions for ISO metric coarse pitch thread of tolerance class 7H cut threads are

given in Table 8.

A-5 Dimensions for ISO metric fine pitch thread of tolerance class 4H are given in Table 9.

A-6 Dimensions for ISO metric fine pitch thread of tolerance class 6H are given in Table 10.

A-7 Dimensions for ISO metric fine pitch thread of tolerance class 7H are given in Table 11.

A-8 Dimensions for ISO metric fine pitch thread of tolerance class 7H cut threads are given in Table 12.

Table 5 Dimensions for ISO Metric Coarse Pitch Thread Taps of Class 4H
(Clause A-1)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Intermediate			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
1.00	0.25	0.835	0.781	0.792	0.935	0.823	0.834	1.022	0.838	0.843	0.854	0.729
1.10	0.25	0.935	0.881	0.892	1.035	0.923	0.934	1.122	0.938	0.943	0.954	0.829
1.20	0.25	1.035	0.981	0.992	1.135	1.023	1.034	1.222	1.038	1.043	1.054	0.929
1.40	0.30	1.199	1.136	1.148	1.319	1.187	1.199	1.424	1.205	1.211	1.223	1.075
1.60	0.35	1.364	1.292	1.305	1.504	1.351	1.365	1.627	1.373	1.379	1.393	1.221
1.80	0.35	1.564	1.492	1.505	1.704	1.551	1.565	1.827	1.573	1.579	1.593	1.421
2.00	0.40	1.728	1.647	1.661	1.888	1.715	1.729	2.028	1.740	1.747	1.761	1.567
2.20	0.45	1.893	1.803	1.818	2.072	1.879	1.894	2.230	1.908	1.915	1.930	1.713
2.50	0.45	2.193	2.103	2.118	2.372	2.179	2.194	2.530	2.208	2.215	2.230	2.013
3.00	0.50	2.657	2.558	2.574	2.857	2.643	2.659	3.032	2.675	2.683	2.699	2.459
3.50	0.60	3.086	2.969	2.987	3.326	3.071	3.089	3.536	3.110	3.119	3.137	2.850
4.00	0.70	3.513	3.380	3.399	3.793	3.499	3.518	4.038	3.545	3.555	3.574	3.242
4.50	0.75	3.976	3.835	3.854	4.275	3.962	3.981	4.538	4.013	4.022	4.041	3.688
5.00	0.80	4.440	4.290	4.310	4.760	4.426	4.446	5.040	4.480	4.490	4.510	4.134
6.00	1.00	5.297	5.112	5.136	5.697	5.282	5.306	6.047	5.350	5.362	5.386	4.917
7.00	1.00	6.297	6.112	6.136	6.697	6.282	6.306	7.047	6.350	6.362	6.386	5.917
8.00	1.25	7.113	6.888	6.913	7.613	7.101	7.126	8.050	7.188	7.201	7.226	6.647
9.00	1.25	8.113	7.888	7.913	8.613	8.101	8.126	9.050	8.188	8.201	8.226	7.647
10.00	1.50	8.931	8.665	8.693	9.531	8.920	8.948	10.056	9.026	9.040	9.068	8.376
11.00	1.50	9.931	9.665	9.693	10.531	9.920	9.948	11.056	10.026	10.040	10.068	9.376
12.00	1.75	10.752	10.442	10.474	11.451	10.739	10.771	12.064	10.863	10.879	10.911	10.106
14.00	2.00	12.568	12.218	12.252	13.368	12.558	12.592	14.068	12.701	12.718	12.752	11.835
16.00	2.00	14.568	14.218	14.252	15.368	14.558	14.592	16.068	14.701	14.718	14.752	13.835
18.00	2.50	16.197	15.769	15.805	17.197	16.194	16.230	18.072	16.376	16.394	16.430	15.294
20.00	2.50	18.197	17.769	17.805	19.197	18.194	18.230	20.072	18.376	18.394	18.430	17.294
22.00	2.50	20.197	19.769	19.805	21.197	20.194	20.230	22.072	20.376	20.394	20.430	19.294
24.00	3.00	21.835	21.323	21.365	23.035	21.833	21.875	24.085	22.051	22.073	22.115	20.752
27.00	3.00	24.835	24.323	24.365	26.035	24.833	24.875	27.085	25.051	25.073	25.115	23.752
30.00	3.50	27.465	26.874	26.919	28.865	27.469	27.514	30.090	27.727	27.749	27.794	26.211
33.00	3.50	30.465	29.874	29.919	31.865	30.469	30.514	33.090	30.727	30.749	30.794	29.211
36.00	4.00	33.094	32.426	32.473	34.694	33.106	33.153	36.094	33.402	33.426	33.473	31.670
39.00	4.00	36.094	35.426	35.473	37.694	36.106	36.153	39.094	36.402	36.426	36.473	34.670
42.00	4.50	38.725	37.977	38.027	40.525	38.742	38.792	42.100	39.077	39.102	39.152	37.129
45.00	4.50	41.725	40.977	41.027	43.525	41.742	41.792	45.100	42.077	42.102	42.152	40.129
48.00	5.00	44.356	43.529	43.582	46.356	44.379	44.432	48.106	44.752	44.779	44.832	42.587
52.00	5.00	48.356	47.529	47.582	50.356	48.379	48.432	52.106	48.752	48.779	48.832	46.587
56.00	5.50	51.987	51.081	51.137	54.187	52.016	52.072	56.112	52.428	52.456	52.512	50.046
60.00	5.50	55.987	55.081	55.137	58.187	56.016	56.072	60.112	56.428	56.456	56.512	54.046
64.00	6.00	59.620	58.633	58.693	62.020	59.653	59.713	64.120	60.103	60.133	60.193	57.505
68.00	6.00	63.620	62.633	62.693	66.020	63.653	63.713	68.120	64.103	64.133	64.193	61.505

Table 6 Dimensions for ISO Metric Coarse Pitch Thread Taps of Class 6H
(Clause A-2)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Intermediate			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
1.00	0.25	0.835	0.792	0.803	0.935	0.834	0.846	1.022	0.838	0.854	0.866	0.729
1.10	0.25	0.935	0.892	0.903	1.035	0.934	0.946	1.122	0.938	0.954	0.966	0.829
1.20	0.25	1.035	0.992	1.003	1.135	1.034	1.046	1.222	1.038	1.054	1.066	0.929
1.40	0.30	1.199	1.148	1.160	1.319	1.199	1.211	1.424	1.205	1.223	1.235	1.075
1.60	0.35	1.364	1.305	1.319	1.504	1.365	1.378	1.627	1.373	1.393	1.406	1.221
1.80	0.35	1.564	1.505	1.519	1.704	1.565	1.578	1.827	1.573	1.593	1.606	1.421
2.00	0.40	1.728	1.661	1.676	1.888	1.729	1.744	2.028	1.740	1.761	1.776	1.567
2.20	0.45	1.893	1.818	1.833	2.072	1.894	1.909	2.230	1.908	1.930	1.945	1.713
2.50	0.45	2.193	2.118	2.133	2.372	2.194	2.209	2.530	2.208	2.230	2.245	2.013
3.00	0.50	2.657	2.574	2.590	2.857	2.659	2.675	3.032	2.675	2.699	2.715	2.459
3.50	0.60	3.086	2.987	3.005	3.326	3.089	3.107	3.536	3.110	3.137	3.155	2.850
4.00	0.70	3.513	3.399	3.418	3.793	3.518	3.537	4.038	3.545	3.574	3.593	3.242
4.50	0.75	3.976	3.854	3.873	4.275	3.981	4.000	4.538	4.013	4.041	4.060	3.688
5.00	0.80	4.440	4.310	4.330	4.760	4.446	4.466	5.040	4.480	4.510	4.530	4.134
6.00	1.00	5.297	5.136	5.159	5.697	5.306	5.329	6.047	5.350	5.386	5.409	4.917
7.00	1.00	6.297	6.136	6.159	6.697	6.306	6.329	7.047	6.350	6.386	6.409	5.917
8.00	1.25	7.113	6.913	6.938	7.613	7.126	7.151	8.050	7.188	7.226	7.251	6.647
9.00	1.25	8.113	7.913	7.938	8.613	8.126	8.151	9.050	8.188	8.226	8.251	7.647
10.00	1.50	8.931	8.693	8.721	9.531	8.948	8.976	10.056	9.026	9.068	9.096	8.376
11.00	1.50	9.931	9.693	9.721	10.531	9.948	9.976	11.056	10.026	10.068	10.096	9.376
12.00	1.75	10.752	10.474	10.506	11.451	10.771	10.803	12.064	10.863	10.911	10.943	10.106
14.00	2.00	12.568	12.252	12.286	13.368	12.592	12.626	14.068	12.701	12.752	12.786	11.835
16.00	2.00	14.568	14.252	14.286	15.368	14.592	14.626	16.068	14.701	14.752	14.786	13.835
18.00	2.50	16.197	15.805	15.841	17.197	16.230	16.266	18.072	16.376	16.430	16.466	15.294
20.00	2.50	18.197	17.805	17.841	19.197	18.230	18.266	20.072	18.376	18.430	18.466	17.294
22.00	2.50	20.197	19.805	19.841	21.197	20.230	20.266	22.072	20.376	20.430	20.466	19.294
24.00	3.00	21.835	21.365	21.407	23.035	21.875	21.917	24.085	22.051	22.115	22.157	20.752
27.00	3.00	24.835	24.365	24.407	26.035	24.875	24.917	27.085	25.051	25.115	25.157	23.752
30.00	3.50	27.465	26.919	26.964	28.865	27.514	27.559	30.090	27.727	27.794	27.839	26.211
33.00	3.50	30.465	29.919	29.964	31.865	30.514	30.559	33.090	30.727	30.794	30.839	29.211
36.00	4.00	33.094	32.473	32.520	34.694	33.153	33.200	36.094	33.402	33.473	33.520	31.670
39.00	4.00	36.094	35.473	35.520	37.694	36.153	36.200	39.094	36.402	36.473	36.520	34.670
42.00	4.50	38.725	38.027	38.077	40.525	38.792	38.842	42.100	39.077	39.152	39.202	37.129
45.00	4.50	41.725	41.027	41.077	43.525	41.792	41.842	45.100	42.077	42.152	42.202	40.129
48.00	5.00	44.356	43.582	43.635	46.356	44.432	44.485	48.106	44.752	44.832	44.885	42.587
52.00	5.00	48.356	47.582	47.635	50.356	48.432	48.485	52.106	48.752	48.832	48.885	46.587
56.00	5.50	51.987	51.137	51.193	54.187	52.072	52.128	56.112	52.428	52.512	52.568	50.046
60.00	5.50	55.987	55.137	55.193	58.187	56.072	56.128	60.112	56.428	56.512	56.568	54.046
64.00	6.00	59.620	58.693	58.753	62.020	59.713	59.773	64.120	60.103	60.193	60.253	57.505
68.00	6.00	63.620	62.693	62.753	66.020	63.713	63.773	68.120	64.103	64.193	64.253	61.505

Table 7 Dimensions for ISO Metric Coarse Pitch Thread Taps of Class 7H
(Clause A-3)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Intermediate			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
1.00	0.25	0.835	0.803	0.814	0.935	0.846	0.857	1.022	0.838	0.866	0.877	0.729
1.10	0.25	0.935	0.903	0.914	1.035	0.946	0.957	1.122	0.938	0.966	0.977	0.829
1.20	0.25	1.035	1.003	1.014	1.135	1.046	1.057	1.222	1.038	1.066	1.077	0.929
1.40	0.30	1.199	1.160	1.172	1.319	1.211	1.223	1.424	1.205	1.235	1.247	1.075
1.60	0.35	1.364	1.319	1.332	1.504	1.378	1.392	1.627	1.373	1.406	1.420	1.221
1.80	0.35	1.564	1.519	1.532	1.704	1.578	1.592	1.827	1.573	1.606	1.620	1.421
2.00	0.40	1.728	1.676	1.690	1.888	1.744	1.758	2.028	1.740	1.776	1.790	1.567
2.20	0.45	1.893	1.833	1.848	2.072	1.909	1.924	2.230	1.908	1.945	1.960	1.713
2.50	0.45	2.193	2.133	2.148	2.372	2.209	2.224	2.530	2.208	2.245	2.260	2.013
3.00	0.50	2.657	2.590	2.606	2.857	2.675	2.691	3.032	2.675	2.715	2.731	2.459
3.50	0.60	3.086	3.005	3.023	3.326	3.107	3.125	3.536	3.110	3.155	3.173	2.850
4.00	0.70	3.513	3.418	3.437	3.793	3.537	3.556	4.038	3.545	3.593	3.612	3.242
4.50	0.75	3.976	3.873	3.892	4.275	4.000	4.019	4.538	4.013	4.060	4.079	3.688
5.00	0.80	4.440	4.330	4.350	4.760	4.466	4.486	5.040	4.480	4.530	4.550	4.134
6.00	1.00	5.297	5.159	5.183	5.697	5.329	5.353	6.047	5.350	5.409	5.433	4.917
7.00	1.00	6.297	6.159	6.183	6.697	6.329	6.353	7.047	6.350	6.409	6.433	5.917
8.00	1.25	7.113	6.938	6.963	7.613	7.151	7.176	8.050	7.188	7.251	7.276	6.647
9.00	1.25	8.113	7.938	7.963	8.613	8.151	8.176	9.050	8.188	8.251	8.276	7.647
10.00	1.50	8.931	8.721	8.749	9.531	8.976	9.004	10.056	9.026	9.096	9.124	8.376
11.00	1.50	9.931	9.721	9.749	10.531	9.976	10.004	11.056	10.026	10.096	10.124	9.376
12.00	1.75	10.752	10.506	10.538	11.451	10.803	10.835	12.064	10.863	10.943	10.975	10.106
14.00	2.00	12.568	12.286	12.320	13.368	12.626	12.660	14.068	12.701	12.786	12.820	11.835
16.00	2.00	14.568	14.286	14.320	15.368	14.626	14.660	16.068	14.701	14.786	14.820	13.835
18.00	2.50	16.197	15.841	15.877	17.197	16.266	16.302	18.072	16.376	16.466	16.502	15.294
20.00	2.50	18.197	17.841	17.877	19.197	18.266	18.302	20.072	18.376	18.466	18.502	17.294
22.00	2.50	20.197	19.841	19.877	21.197	20.266	20.302	22.072	20.376	20.466	20.502	19.294
24.00	3.00	21.835	21.407	21.450	23.035	21.917	21.960	24.085	22.051	22.157	22.200	20.752
27.00	3.00	24.835	24.407	24.450	26.035	24.917	24.960	27.085	25.051	25.157	25.200	23.752
30.00	3.50	27.465	26.964	27.008	28.865	27.559	27.603	30.090	27.727	27.839	27.883	26.211
33.00	3.50	30.465	29.964	30.008	31.865	30.559	30.603	33.090	30.727	30.839	30.883	29.211
36.00	4.00	33.094	32.520	32.567	34.694	33.200	33.247	36.094	33.402	33.520	33.567	31.670
39.00	4.00	36.094	35.520	35.567	37.694	36.200	36.247	39.094	36.402	36.520	36.567	34.670
42.00	4.50	38.725	38.077	38.127	40.525	38.842	38.892	42.100	39.077	39.202	39.252	37.129
45.00	4.50	41.725	41.077	41.127	43.525	41.842	41.892	45.100	42.077	42.202	42.252	40.129
48.00	5.00	44.356	43.635	43.688	46.356	44.485	44.538	48.106	44.752	44.885	44.938	42.587
52.00	5.00	48.356	47.635	47.688	50.356	48.485	48.538	52.106	48.752	48.885	48.938	46.587
56.00	5.50	51.987	51.193	51.249	54.187	52.128	52.184	56.112	52.428	52.568	52.624	50.046
60.00	5.50	55.987	55.193	55.249	58.187	56.128	56.184	60.112	56.428	56.568	56.624	54.046
64.00	6.00	59.620	58.753	58.813	62.020	59.773	59.833	64.120	60.103	60.253	60.313	57.505
68.00	6.00	63.620	62.753	62.813	66.020	63.773	63.833	68.120	64.103	64.253	64.313	61.505

Table 8 Dimensions for ISO Metric Coarse Pitch Thread Taps of Class 7H Cut
(Clause A-4)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Intermediate			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
1.00	0.25	0.835	0.786	0.809	0.935	0.829	0.851	1.022	0.838	0.849	0.871	0.729
1.10	0.25	0.935	0.886	0.909	1.035	0.929	0.951	1.122	0.938	0.949	0.971	0.829
1.20	0.25	1.035	0.986	1.009	1.135	1.029	1.051	1.222	1.038	1.049	1.071	0.929
1.40	0.30	1.199	1.142	1.166	1.319	1.193	1.217	1.424	1.205	1.217	1.241	1.075
1.60	0.35	1.364	1.299	1.325	1.504	1.358	1.385	1.627	1.373	1.386	1.413	1.221
1.80	0.35	1.564	1.499	1.525	1.704	1.558	1.585	1.827	1.573	1.586	1.613	1.421
2.00	0.40	1.728	1.654	1.683	1.888	1.722	1.751	2.028	1.740	1.754	1.783	1.567
2.20	0.45	1.893	1.810	1.840	2.072	1.887	1.917	2.230	1.908	1.923	1.953	1.713
2.50	0.45	2.193	2.110	2.140	2.372	2.187	2.217	2.530	2.208	2.223	2.253	2.013
3.00	0.50	2.657	2.566	2.598	2.857	2.651	2.683	3.032	2.675	2.691	2.723	2.459
3.50	0.60	3.086	2.978	3.014	3.326	3.080	3.116	3.536	3.110	3.128	3.164	2.850
4.00	0.70	3.513	3.389	3.427	3.793	3.508	3.546	4.038	3.545	3.564	3.602	3.242
4.50	0.75	3.976	3.844	3.882	4.275	3.972	4.010	4.538	4.013	4.032	4.070	3.688
5.00	0.80	4.440	4.300	4.340	4.760	4.436	4.476	5.040	4.480	4.500	4.540	4.134
6.00	1.00	5.297	5.124	5.171	5.697	5.294	5.341	6.047	5.350	5.374	5.421	4.917
7.00	1.00	6.297	6.124	6.171	6.697	6.294	6.341	7.047	6.350	6.374	6.421	5.917
8.00	1.25	7.113	6.901	6.951	7.613	7.113	7.163	8.050	7.188	7.213	7.263	6.647
9.00	1.25	8.113	7.901	7.951	8.613	8.113	8.163	9.050	8.188	8.213	8.263	7.647
10.00	1.50	8.931	8.679	8.735	9.531	8.934	8.990	10.056	9.026	9.054	9.110	8.376
11.00	1.50	9.931	9.679	9.735	10.531	9.934	9.990	11.056	10.026	10.054	10.110	9.376
12.00	1.75	10.752	10.458	10.522	11.451	10.755	10.819	12.064	10.863	10.895	10.959	10.106
14.00	2.00	12.568	12.235	12.303	13.368	12.575	12.643	14.068	12.701	12.735	12.803	11.835
16.00	2.00	14.568	14.235	14.303	15.368	14.575	14.643	16.068	14.701	14.735	14.803	13.835
18.00	2.50	16.197	15.787	15.859	17.197	16.212	16.284	18.072	16.376	16.412	16.484	15.294
20.00	2.50	18.197	17.787	17.859	19.197	18.212	18.284	20.072	18.376	18.412	18.484	17.294
22.00	2.50	20.197	19.787	19.859	21.197	20.212	20.284	22.072	20.376	20.412	20.484	19.294
24.00	3.00	21.835	21.344	21.429	23.035	21.854	21.939	24.085	22.051	22.094	22.179	20.752
27.00	3.00	24.835	24.344	24.429	26.035	24.854	24.939	27.085	25.051	25.094	25.179	23.752
30.00	3.50	27.465	26.896	26.986	28.865	27.491	27.581	30.090	27.727	27.771	27.861	26.211
33.00	3.50	30.465	29.896	29.986	31.865	30.491	30.581	33.090	30.727	30.771	30.861	29.211
36.00	4.00	33.094	32.449	32.544	34.694	33.129	33.224	36.094	33.402	33.449	33.544	31.670
39.00	4.00	36.094	35.449	35.544	37.694	36.129	36.224	39.094	36.402	36.449	36.544	34.670
42.00	4.50	38.725	38.002	38.102	40.525	38.767	38.867	42.100	39.077	39.127	39.227	37.129
45.00	4.50	41.725	41.002	41.102	43.525	41.767	41.867	45.100	42.077	42.127	42.227	40.129
48.00	5.00	44.356	43.555	43.661	46.356	44.405	44.511	48.106	44.752	44.805	44.911	42.587
52.00	5.00	48.356	47.555	47.661	50.356	48.405	48.511	52.106	48.752	48.805	48.911	46.587
56.00	5.50	51.987	51.109	51.221	54.187	52.044	52.156	56.112	52.428	52.484	52.596	50.046
60.00	5.50	55.987	55.109	55.221	58.187	56.044	56.156	60.112	56.428	56.484	56.596	54.046
64.00	6.00	59.620	58.663	58.783	62.020	59.683	59.803	64.120	60.103	60.163	60.283	57.505
68.00	6.00	63.620	62.663	62.783	66.020	63.683	63.803	68.120	64.103	64.163	64.283	61.505

Table 9 Dimensions for ISO Metric Fine Pitch Thread Taps of Class 4H
(Clause A-5)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
2.00	0.25	1.911	1.814	1.826	2.024	1.838	1.844	1.856	1.729
2.20	0.25	2.112	2.014	2.026	2.224	2.038	2.044	2.056	1.929
2.50	0.35	2.369	2.237	2.251	2.527	2.273	2.279	2.293	2.121
3.00	0.35	2.871	2.738	2.752	3.028	2.773	2.780	2.794	2.621
3.50	0.35	3.371	3.238	3.252	3.528	3.273	3.280	3.294	3.121
4.00	0.50	3.807	3.623	3.639	4.032	3.675	3.683	3.699	3.459
4.50	0.50	4.307	4.123	4.139	4.532	4.175	4.183	4.199	3.959
5.00	0.50	4.807	4.623	4.639	5.032	4.675	4.683	4.699	4.459
5.50	0.50	5.307	5.123	5.139	5.532	5.175	5.183	5.199	4.959
6.00	0.75	5.705	5.433	5.455	6.042	5.513	5.523	5.545	5.188
7.00	0.75	6.705	6.433	6.455	7.042	6.513	6.523	6.545	6.188
8.00	0.75	7.705	7.433	7.455	8.042	7.513	7.523	7.545	7.188
8.00	1.00	7.597	7.242	7.266	8.047	7.350	7.362	7.386	6.917
9.00	0.75	8.705	8.433	8.455	9.042	8.513	8.523	8.545	8.188
9.00	1.00	8.597	8.242	8.266	9.047	8.350	8.362	8.386	7.917
10.00	0.75	9.705	9.433	9.455	10.042	9.513	9.523	9.545	9.188
10.00	1.00	9.597	9.242	9.266	10.047	9.350	9.362	9.386	8.917
10.00	1.25	9.488	9.051	9.076	10.050	9.188	9.201	9.226	8.647
11.00	0.75	10.705	10.433	10.455	11.042	10.513	10.523	10.545	10.188
11.00	1.00	10.597	10.242	10.266	11.047	10.350	10.362	10.386	9.917
12.00	1.00	11.600	11.243	11.268	12.050	11.350	11.363	11.388	10.917
12.00	1.25	11.493	11.052	11.080	12.056	11.188	11.202	11.230	10.647
12.00	1.50	11.385	10.861	10.891	12.060	11.026	11.041	11.071	10.376
14.00	1.00	13.600	13.243	13.268	14.050	13.350	13.363	13.388	12.917
14.00	1.25	13.493	13.052	13.080	14.056	13.188	13.202	13.230	12.647
14.00	1.50	13.385	12.861	12.891	14.060	13.026	13.041	13.071	12.376
15.00	1.00	14.600	14.243	14.268	15.050	14.350	14.363	14.388	13.917
15.00	1.50	14.385	13.861	13.891	15.060	14.026	14.041	14.071	13.376
16.00	1.00	15.600	15.243	15.268	16.050	15.350	15.363	15.388	14.917
16.00	1.50	15.385	14.861	14.891	16.060	15.026	15.041	15.071	14.376
17.00	1.00	16.600	16.243	16.268	17.050	16.350	16.363	16.388	15.917
17.00	1.50	16.385	15.861	15.891	17.060	16.026	16.041	16.071	15.376
18.00	1.00	17.600	17.243	17.268	18.050	17.350	17.363	17.388	16.917
18.00	1.50	17.385	16.861	16.891	18.060	17.026	17.041	17.071	16.376
18.00	2.00	17.168	16.478	16.512	18.068	16.701	16.718	16.752	15.835
20.00	1.00	19.600	19.243	19.268	20.050	19.350	19.363	19.388	18.917
20.00	1.50	19.385	18.861	18.891	20.060	19.026	19.041	19.071	18.376
20.00	2.00	19.168	18.478	18.512	20.068	18.701	18.718	18.752	17.835
22.00	1.00	21.600	21.243	21.268	22.050	21.350	21.363	21.388	20.917
22.00	1.50	21.385	20.861	20.891	22.060	21.026	21.041	21.071	20.376
22.00	2.00	21.168	20.478	20.512	22.068	20.701	20.718	20.752	19.835
24.00	1.00	23.603	23.244	23.270	24.053	23.350	23.364	23.390	22.917
24.00	1.50	23.389	22.862	22.894	24.064	23.026	23.042	23.074	22.376
24.00	2.00	23.172	22.479	22.515	24.072	22.701	22.719	22.755	21.835
25.00	1.00	24.603	24.244	24.270	25.053	24.350	24.364	24.390	23.917

Table 9 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	$d_{1B}Max$
25.00	1.50	24.389	23.862	23.894	25.064	24.026	24.042	24.074	23.376
25.00	2.00	24.172	23.479	23.515	25.072	23.701	23.719	23.755	22.835
26.00	1.50	25.389	24.862	24.894	26.064	25.026	25.042	25.074	24.376
27.00	1.00	26.603	26.244	26.270	27.053	26.350	26.364	26.390	25.917
27.00	1.50	26.389	25.862	25.894	27.064	26.026	26.042	26.074	25.376
27.00	2.00	26.172	25.479	25.515	27.072	25.701	25.719	25.755	24.835
28.00	1.00	27.603	27.244	27.270	28.053	27.350	27.364	27.390	26.917
28.00	1.50	27.389	26.862	26.894	28.064	27.026	27.042	27.074	26.376
28.00	2.00	27.172	26.479	26.515	28.072	26.701	26.719	26.755	25.835
30.00	1.00	29.603	29.244	29.270	30.053	29.350	29.364	29.390	28.917
30.00	1.50	29.389	28.862	28.894	30.064	29.026	29.042	29.074	28.376
30.00	2.00	29.172	28.479	28.515	30.072	28.701	28.719	28.755	27.835
30.00	3.00	28.735	27.713	27.755	30.085	28.051	28.073	28.115	26.752
32.00	1.50	31.389	30.862	30.894	32.064	31.026	31.042	31.074	30.376
32.00	2.00	31.172	30.479	30.515	32.072	30.701	30.719	30.755	29.835
33.00	1.50	32.389	31.862	31.894	33.064	32.026	32.042	32.074	31.376
33.00	2.00	32.172	31.479	31.515	33.072	31.701	31.719	31.755	30.835
33.00	3.00	31.735	30.713	30.755	33.085	31.051	31.073	31.115	29.752
35.00	1.50	34.389	33.862	33.894	35.064	34.026	34.042	34.074	33.376
36.00	1.50	35.389	34.862	34.894	36.064	35.026	35.042	35.074	34.376
36.00	2.00	35.172	34.479	34.515	36.072	34.701	34.719	34.755	33.835
36.00	3.00	34.735	33.713	33.755	36.085	34.051	34.073	34.115	32.752
38.00	1.50	37.389	36.862	36.894	38.064	37.026	37.042	37.074	36.376
39.00	1.50	38.389	37.862	37.894	39.064	38.026	38.042	38.074	37.376
39.00	2.00	38.172	37.479	37.515	39.072	37.701	37.719	37.755	36.835
39.00	3.00	37.735	36.713	36.755	39.085	37.051	37.073	37.115	35.752
40.00	1.50	39.389	38.862	38.894	40.064	39.026	39.042	39.074	38.376
40.00	2.00	39.172	38.479	38.515	40.072	38.701	38.719	38.755	37.835
40.00	3.00	38.735	37.713	37.755	40.085	38.051	38.073	38.115	36.752
42.00	1.50	41.389	40.862	40.894	42.064	41.026	41.042	41.074	40.376
42.00	2.00	41.172	40.479	40.515	42.072	40.701	40.719	40.755	39.835
42.00	3.00	40.735	39.713	39.755	42.085	40.051	40.073	40.115	38.752
42.00	4.00	40.294	38.946	38.993	42.094	39.402	39.426	39.473	37.670
45.00	1.50	44.389	43.862	43.894	45.064	44.026	44.042	44.074	43.376
45.00	2.00	44.172	43.479	43.515	45.072	43.701	43.719	43.755	42.835
45.00	3.00	43.735	42.713	42.755	45.085	43.051	43.073	43.115	41.752
45.00	4.00	43.294	41.946	41.993	45.094	42.402	42.426	42.473	40.670
48.00	1.50	47.393	46.863	46.897	48.068	47.026	47.043	47.077	46.376
48.00	2.00	47.176	46.480	46.518	48.076	46.701	46.720	46.758	45.835
48.00	3.00	46.740	45.714	45.759	48.090	46.051	46.074	46.119	44.752
48.00	4.00	46.300	44.947	44.997	48.100	45.402	45.427	45.477	43.670
50.00	1.50	49.393	48.863	48.897	50.068	49.026	49.043	49.077	48.376
50.00	2.00	49.176	48.480	48.518	50.076	48.701	48.720	48.758	47.835
50.00	3.00	48.740	47.714	47.759	50.090	48.051	48.074	48.119	46.752
52.00	1.50	51.393	50.863	50.897	52.068	51.026	51.043	51.077	50.376

Table 9 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
52.00	2.00	51.176	50.480	50.518	52.076	50.701	50.720	50.758	49.835
52.00	3.00	50.740	49.714	49.759	52.090	50.051	50.074	50.119	48.752
52.00	4.00	50.300	48.947	48.997	52.100	49.402	49.427	49.477	47.670
55.00	1.50	54.393	53.863	53.897	55.068	54.026	54.043	54.077	53.376
55.00	2.00	54.176	53.480	53.518	55.076	53.701	53.720	53.758	52.835
55.00	3.00	53.740	52.714	52.759	55.090	53.051	53.074	53.119	51.752
55.00	4.00	53.300	51.947	51.997	55.100	52.402	52.427	52.477	50.670
56.00	1.50	55.393	54.863	54.897	56.068	55.026	55.043	55.077	54.376
56.00	2.00	55.176	54.480	54.518	56.076	54.701	54.720	54.758	53.835
56.00	3.00	54.740	53.714	53.759	56.090	54.051	54.074	54.119	52.752
56.00	4.00	54.300	52.947	52.997	56.100	53.402	53.427	53.477	51.670
58.00	1.50	57.393	56.863	56.897	58.068	57.026	57.043	57.077	56.376
58.00	2.00	57.176	56.480	56.518	58.076	56.701	56.720	56.758	55.835
58.00	3.00	56.740	55.714	55.759	58.090	56.051	56.074	56.119	54.752
58.00	4.00	56.300	54.947	54.997	58.100	55.402	55.427	55.477	53.670
60.00	1.50	59.393	58.863	58.897	60.068	59.026	59.043	59.077	58.376
60.00	2.00	59.176	58.480	58.518	60.076	58.701	58.720	58.758	57.835
60.00	3.00	58.740	57.714	57.759	60.090	58.051	58.074	58.119	56.752
60.00	4.00	58.300	56.947	56.997	60.100	57.402	57.427	57.477	55.670
62.00	1.50	61.393	60.863	60.897	62.068	61.026	61.043	61.077	60.376
62.00	2.00	61.176	60.480	60.518	62.076	60.701	60.720	60.758	59.835
62.00	3.00	60.740	59.714	59.759	62.090	60.051	60.074	60.119	58.752
62.00	4.00	60.300	58.947	58.997	62.100	59.402	59.427	59.477	57.670
64.00	1.50	63.393	62.863	62.897	64.068	63.026	63.043	63.077	62.376
64.00	2.00	63.176	62.480	62.518	64.076	62.701	62.720	62.758	61.835
64.00	3.00	62.740	61.714	61.759	64.090	62.051	62.074	62.119	60.752
64.00	4.00	62.300	60.947	60.997	64.100	61.402	61.427	61.477	59.670
65.00	1.50	64.393	63.863	63.897	65.068	64.026	64.043	64.077	63.376
65.00	2.00	64.176	63.480	63.518	65.076	63.701	63.720	63.758	62.835
65.00	3.00	63.740	62.714	62.759	65.090	63.051	63.074	63.119	61.752
65.00	4.00	63.300	61.947	61.997	65.100	62.402	62.427	62.477	60.670
68.00	1.50	67.393	66.863	66.897	68.068	67.026	67.043	67.077	66.376
68.00	2.00	67.176	66.480	66.518	68.076	66.701	66.720	66.758	65.835
68.00	3.00	66.740	65.714	65.759	68.090	66.051	66.074	66.119	64.752
68.00	4.00	66.300	64.947	64.997	68.100	65.402	65.427	65.477	63.670
70.00	1.50	69.393	68.863	68.897	70.068	69.026	69.043	69.077	68.376
70.00	2.00	69.176	68.480	68.518	70.076	68.701	68.720	68.758	67.835
70.00	3.00	68.740	67.714	67.759	70.090	68.051	68.074	68.119	66.752
70.00	4.00	68.300	66.947	66.997	70.100	67.402	67.427	67.477	65.670
70.00	6.00	67.420	65.413	65.473	70.120	66.103	66.133	66.193	63.505
72.00	1.50	71.393	70.863	70.897	72.068	71.026	71.043	71.077	70.376
72.00	2.00	71.176	70.480	70.518	72.076	70.701	70.720	70.758	69.835
72.00	3.00	70.740	69.714	69.759	72.090	70.051	70.074	70.119	68.752
72.00	4.00	70.300	68.947	68.997	72.100	69.402	69.427	69.477	67.670
72.00	6.00	69.420	67.413	67.473	72.120	68.103	68.133	68.193	65.505

Table 9 (Concluded)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	d_{1BMax}
75.00	1.50	74.393	73.863	73.897	75.068	74.026	74.043	74.077	73.376
75.00	2.00	74.176	73.480	73.518	75.076	73.701	73.720	73.758	72.835
75.00	3.00	73.740	72.714	72.759	75.090	73.051	73.074	73.119	71.752
75.00	4.00	73.300	71.947	71.997	75.100	72.402	72.427	72.477	70.670
76.00	1.50	75.393	74.863	74.897	76.068	75.026	75.043	75.077	74.376
76.00	2.00	75.176	74.480	74.518	76.076	74.701	74.720	74.758	73.835
76.00	3.00	74.740	73.714	73.759	76.090	74.051	74.074	74.119	72.752
76.00	4.00	74.300	72.947	72.997	76.100	73.402	73.427	73.477	71.670
76.00	6.00	73.420	71.413	71.473	76.120	72.103	72.133	72.193	69.505
78.00	2.00	77.176	76.480	76.518	78.076	76.701	76.720	76.758	75.835
80.00	1.50	79.393	78.863	78.897	80.068	79.026	79.043	79.077	78.376
80.00	2.00	79.176	78.480	78.518	80.076	78.701	78.720	78.758	77.835
80.00	3.00	78.740	77.714	77.759	80.090	78.051	78.074	78.119	76.752
80.00	4.00	78.300	76.947	76.997	80.100	77.402	77.427	77.477	75.670
80.00	6.00	77.420	75.413	75.473	80.120	76.103	76.133	76.193	73.505
82.00	2.00	81.176	80.480	80.518	82.076	80.701	80.720	80.758	79.835
85.00	2.00	84.176	83.480	83.518	85.076	83.701	83.720	83.758	82.835
85.00	3.00	83.740	82.714	82.759	85.090	83.051	83.074	83.119	81.752
85.00	4.00	83.300	81.947	81.997	85.100	82.402	82.427	82.477	80.670
85.00	6.00	82.420	80.413	80.473	85.120	81.103	81.133	81.193	78.505
90.00	2.00	89.176	88.480	88.518	90.076	88.701	88.720	88.758	87.835
90.00	3.00	88.740	87.714	87.759	90.090	88.051	88.074	88.119	86.752
90.00	4.00	88.300	86.947	86.997	90.100	87.402	87.427	87.477	85.670
90.00	6.00	87.420	85.413	85.473	90.120	86.103	86.133	86.193	83.505
95.00	2.00	94.180	93.481	93.521	95.080	93.701	93.721	93.761	92.835
95.00	3.00	93.744	92.715	92.762	95.094	93.051	93.075	93.122	91.752
95.00	4.00	93.306	91.948	92.001	95.106	92.402	92.428	92.481	90.670
95.00	6.00	92.426	90.414	90.477	95.126	91.103	91.134	91.197	88.505
100.00	2.00	99.180	98.481	98.521	100.080	98.701	98.721	98.761	97.835
100.00	3.00	98.744	97.715	97.762	100.094	98.051	98.075	98.122	96.752
100.00	4.00	98.306	96.948	97.001	100.106	97.402	97.428	97.481	95.670
100.00	6.00	97.426	95.414	95.477	100.126	96.103	96.134	96.197	93.505

IS 6173 (Part 1) : 1992

Table 10 Dimensions for ISO Metric Fine Pitch Thread Taps of Class 6H
(Clause A-6)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
2.00	0.25	1.911	1.826	1.838	2.024	1.838	1.856	1.868	1.729
2.20	0.25	2.112	2.026	2.038	2.224	2.038	2.056	2.068	1.929
2.50	0.35	2.369	2.251	2.264	2.527	2.273	2.293	2.306	2.121
3.00	0.35	2.871	2.752	2.766	3.028	2.773	2.794	2.808	2.621
3.50	0.35	3.371	3.252	3.266	3.528	3.273	3.294	3.308	3.121
4.00	0.50	3.807	3.639	3.655	4.032	3.675	3.699	3.715	3.459
4.50	0.50	4.307	4.139	4.155	4.532	4.175	4.199	4.215	3.959
5.00	0.50	4.807	4.639	4.655	5.032	4.675	4.699	4.715	4.459
5.50	0.50	5.307	5.139	5.155	5.532	5.175	5.199	5.215	4.959
6.00	0.75	5.705	5.455	5.476	6.042	5.513	5.545	5.566	5.188
7.00	0.75	6.705	6.455	6.476	7.042	6.513	6.545	6.566	6.188
8.00	0.75	7.705	7.455	7.476	8.042	7.513	7.545	7.566	7.188
8.00	1.00	7.597	7.266	7.289	8.047	7.350	7.386	7.409	6.917
9.00	0.75	8.705	8.455	8.476	9.042	8.513	8.545	8.566	8.188
9.00	1.00	8.597	8.266	8.289	9.047	8.350	8.386	8.409	7.917
10.00	0.75	9.705	9.455	9.476	10.042	9.513	9.545	9.566	9.188
10.00	1.00	9.597	9.266	9.289	10.047	9.350	9.386	9.409	8.917
10.00	1.25	9.488	9.076	9.101	10.050	9.188	9.226	9.251	8.647
11.00	0.75	10.705	10.455	10.476	11.042	10.513	10.545	10.566	10.188
11.00	1.00	10.597	10.266	10.289	11.047	10.350	10.386	10.409	9.917
12.00	1.00	11.600	11.268	11.293	12.050	11.350	11.388	11.413	10.917
12.00	1.25	11.493	11.080	11.108	12.056	11.188	11.230	11.258	10.647
12.00	1.50	11.385	10.891	10.921	12.060	11.026	11.071	11.101	10.376
14.00	1.00	13.600	13.268	13.293	14.050	13.350	13.388	13.413	12.917
14.00	1.25	13.493	13.080	13.108	14.056	13.188	13.230	13.258	12.647
14.00	1.50	13.385	12.891	12.921	14.060	13.026	13.071	13.101	12.376
15.00	1.00	14.600	14.268	14.293	15.050	14.350	14.388	14.413	13.917
15.00	1.50	14.385	13.891	13.921	15.060	14.026	14.071	14.101	13.376
16.00	1.00	15.600	15.268	15.293	16.050	15.350	15.388	15.413	14.917
16.00	1.50	15.385	14.891	14.921	16.060	15.026	15.071	15.101	14.376
17.00	1.00	16.600	16.268	16.293	17.050	16.350	16.388	16.413	15.917
17.00	1.50	16.385	15.891	15.921	17.060	16.026	16.071	16.101	15.376
18.00	1.00	17.600	17.268	17.293	18.050	17.350	17.388	17.413	16.917
18.00	1.50	17.385	16.891	16.921	18.060	17.026	17.071	17.101	16.376
18.00	2.00	17.168	16.512	16.546	18.068	16.701	16.752	16.786	15.835
20.00	1.00	19.600	19.268	19.293	20.050	19.350	19.388	19.413	18.917
20.00	1.50	19.385	18.891	18.921	20.060	19.026	19.071	19.101	18.376
20.00	2.00	19.168	18.512	18.546	20.068	18.701	18.752	18.786	17.835
22.00	1.00	21.600	21.268	21.293	22.050	21.350	21.388	21.413	20.917
22.00	1.50	21.385	20.891	20.921	22.060	21.026	21.071	21.101	20.376
22.00	2.00	21.168	20.512	20.546	22.068	20.701	20.752	20.786	19.835
24.00	1.00	23.603	23.270	23.296	24.053	23.350	23.390	23.416	22.917
24.00	1.50	23.389	22.894	22.926	24.064	23.026	23.074	23.106	22.376
24.00	2.00	23.172	22.515	22.551	24.072	22.701	22.755	22.791	21.835
25.00	1.00	24.603	24.270	24.296	25.053	24.350	24.390	24.416	23.917

Table 10 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	d_{1BMax}
25.00	1.50	24.389	23.894	23.926	25.064	24.026	24.074	24.106	23.376
25.00	2.00	24.172	23.515	23.551	25.072	23.701	23.755	23.791	22.835
26.00	1.50	25.389	24.894	24.926	26.064	25.026	25.074	25.106	24.376
27.00	1.00	26.603	26.270	26.296	27.053	26.350	26.390	26.416	25.917
27.00	1.50	26.389	25.894	25.926	27.064	26.026	26.074	26.106	25.376
27.00	2.00	26.172	25.515	25.551	27.072	25.701	25.755	25.791	24.835
28.00	1.00	27.603	27.270	27.296	28.053	27.350	27.390	27.416	26.917
28.00	1.50	27.389	26.894	26.926	28.064	27.026	27.074	27.106	26.376
28.00	2.00	27.172	26.515	26.551	28.072	26.701	26.755	26.791	25.835
30.00	1.00	29.603	29.270	29.296	30.053	29.350	29.390	29.416	28.917
30.00	1.50	29.389	28.894	28.926	30.064	29.026	29.074	29.106	28.376
30.00	2.00	29.172	28.515	28.551	30.072	28.701	28.755	28.791	27.835
30.00	3.00	28.735	27.755	27.797	30.085	28.051	28.115	28.157	26.752
32.00	1.50	31.389	30.894	30.926	32.064	31.026	31.074	31.106	30.376
32.00	2.00	31.172	30.515	30.551	32.072	30.701	30.755	30.791	29.835
33.00	1.50	32.389	31.894	31.926	33.064	32.026	32.074	32.106	31.376
33.00	2.00	32.172	31.515	31.551	33.072	31.701	31.755	31.791	30.835
33.00	3.00	31.735	30.755	30.797	33.085	31.051	31.115	31.157	29.752
35.00	1.50	34.389	33.894	33.926	35.064	34.026	34.074	34.106	33.376
36.00	1.50	35.389	34.894	34.926	36.064	35.026	35.074	35.106	34.376
36.00	2.00	35.172	34.515	34.551	36.072	34.701	34.755	34.791	33.835
36.00	3.00	34.735	33.755	33.797	36.085	34.051	34.115	34.157	32.752
38.00	1.50	37.389	36.894	36.926	38.064	37.026	37.074	37.106	36.376
39.00	1.50	38.389	37.894	37.926	39.064	38.026	38.074	38.106	37.376
39.00	2.00	38.172	37.515	37.551	39.072	37.701	37.755	37.791	36.835
39.00	3.00	37.735	36.755	36.797	39.085	37.051	37.115	37.157	35.752
40.00	1.50	39.389	38.894	38.926	40.064	39.026	39.074	39.106	38.376
40.00	2.00	39.172	38.515	38.551	40.072	38.701	38.755	38.791	37.835
40.00	3.00	38.735	37.755	37.797	40.085	38.051	38.115	38.157	36.752
42.00	1.50	41.389	40.894	40.926	42.064	41.026	41.074	41.106	40.376
42.00	2.00	41.172	40.515	40.551	42.072	40.701	40.755	40.791	39.835
42.00	3.00	40.735	39.755	39.797	42.085	40.051	40.115	40.157	38.752
42.00	4.00	40.294	38.993	39.040	42.094	39.402	39.473	39.520	37.670
45.00	1.50	44.389	43.894	43.926	45.064	44.026	44.074	44.106	43.376
45.00	2.00	44.172	43.515	43.551	45.072	43.701	43.755	43.791	42.835
45.00	3.00	43.735	42.755	42.797	45.085	43.051	43.115	43.157	41.752
45.00	4.00	43.294	41.993	42.040	45.094	42.402	42.473	42.520	40.670
48.00	1.50	47.393	46.897	46.931	48.068	47.026	47.077	47.111	46.376
48.00	2.00	47.176	46.518	46.556	48.076	46.701	46.758	46.796	45.835
48.00	3.00	46.740	45.759	45.803	48.090	46.051	46.119	46.163	44.752
48.00	4.00	46.300	44.997	45.047	48.100	45.402	45.477	45.527	43.670
50.00	1.50	49.393	48.897	48.931	50.068	49.026	49.077	49.111	48.376
50.00	2.00	49.176	48.518	48.556	50.076	48.701	48.758	48.796	47.835
50.00	3.00	48.740	47.759	47.803	50.090	48.051	48.119	48.163	46.752
52.00	1.50	51.393	50.897	50.931	52.068	51.026	51.077	51.111	50.376

Table 10 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
52.00	2.00	51.176	50.518	50.556	52.076	50.701	50.758	50.796	49.835
52.00	3.00	50.740	49.759	49.803	52.090	50.051	50.119	50.163	48.752
52.00	4.00	50.300	48.997	49.047	52.100	49.402	49.477	49.527	47.670
55.00	1.50	54.393	53.897	53.931	55.068	54.026	54.077	54.111	53.376
55.00	2.00	54.176	53.518	53.556	55.076	53.701	53.758	53.796	52.835
55.00	3.00	53.740	52.759	52.803	55.090	53.051	53.119	53.163	51.752
55.00	4.00	53.300	51.997	52.047	55.100	52.402	52.477	52.527	50.670
56.00	1.50	55.393	54.897	54.931	56.068	55.026	55.077	55.111	54.376
56.00	2.00	55.176	54.518	54.556	56.076	54.701	54.758	54.796	53.835
56.00	3.00	54.740	53.759	53.803	56.090	54.051	54.119	54.163	52.752
56.00	4.00	54.300	52.997	53.047	56.100	53.402	53.477	53.527	51.670
58.00	1.50	57.393	56.897	56.931	58.068	57.026	57.077	57.111	56.376
58.00	2.00	57.176	56.518	56.556	58.076	56.701	56.758	56.796	55.835
58.00	3.00	56.740	55.759	55.803	58.090	56.051	56.119	56.163	54.752
58.00	4.00	56.300	54.997	55.047	58.100	55.402	55.477	55.527	53.670
60.00	1.50	59.393	58.897	58.931	60.068	59.026	59.077	59.111	58.376
60.00	2.00	59.176	58.518	58.556	60.076	58.701	58.758	58.796	57.835
60.00	3.00	58.740	57.759	57.803	60.090	58.051	58.119	58.163	56.752
60.00	4.00	58.300	56.997	57.047	60.100	57.402	57.477	57.527	55.670
62.00	1.50	61.393	60.897	60.931	62.068	61.026	61.077	61.111	60.376
62.00	2.00	61.176	60.518	60.556	62.076	60.701	60.758	60.796	59.835
62.00	3.00	60.740	59.759	59.803	62.090	60.051	60.119	60.163	58.752
62.00	4.00	60.300	58.997	59.047	62.100	59.402	59.477	59.527	57.670
64.00	1.50	63.393	62.897	62.931	64.068	63.026	63.077	63.111	62.376
64.00	2.00	63.176	62.518	62.556	64.076	62.701	62.758	62.796	61.835
64.00	3.00	62.740	61.759	61.803	64.090	62.051	62.119	62.163	60.752
64.00	4.00	62.300	60.997	61.047	64.100	61.402	61.477	61.527	59.670
65.00	1.50	64.393	63.897	63.931	65.068	64.026	64.077	64.111	63.376
65.00	2.00	64.176	63.518	63.556	65.076	63.701	63.758	63.796	62.835
65.00	3.00	63.740	62.759	62.803	65.090	63.051	63.119	63.163	61.752
65.00	4.00	63.300	61.997	62.047	65.100	62.402	62.477	62.527	60.670
68.00	1.50	67.393	66.897	66.931	68.068	67.026	67.077	67.111	66.376
68.00	2.00	67.176	66.518	66.556	68.076	66.701	66.758	66.796	65.835
68.00	3.00	66.740	65.759	65.803	68.090	66.051	66.119	66.163	64.752
68.00	4.00	66.300	64.997	65.047	68.100	65.402	65.477	65.527	63.670
70.00	1.50	69.393	68.897	68.931	70.068	69.026	69.077	69.111	68.376
70.00	2.00	69.176	68.518	68.556	70.076	68.701	68.758	68.796	67.835
70.00	3.00	68.740	67.759	67.803	70.090	68.051	68.119	68.163	66.752
70.00	4.00	68.300	66.997	67.047	70.100	67.402	67.477	67.527	65.670
70.00	6.00	67.420	65.473	65.533	70.120	66.103	66.193	66.253	63.505
72.00	1.50	71.393	70.897	70.931	72.068	71.026	71.077	71.111	70.376
72.00	2.00	71.176	70.518	70.556	72.076	70.701	70.758	70.796	69.835
72.00	3.00	70.740	69.759	69.803	72.090	70.051	70.119	70.163	68.752
72.00	4.00	70.300	68.997	69.047	72.100	69.402	69.477	69.527	67.670
72.00	6.00	69.420	67.473	67.533	72.120	68.103	68.193	68.253	65.505

Table 10 (Concluded)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	$d_{1B}Max$
75.00	1.50	74.393	73.897	73.931	75.068	74.026	74.077	74.111	73.376
75.00	2.00	74.176	73.518	73.556	75.076	73.701	73.758	73.796	72.835
75.00	3.00	73.740	72.759	72.803	75.090	73.051	73.119	73.163	71.752
75.00	4.00	73.300	71.997	72.047	75.100	72.402	72.477	72.527	70.670
76.00	1.50	75.393	74.897	74.931	76.068	75.026	75.077	75.111	74.376
76.00	2.00	75.176	74.518	74.556	76.076	74.701	74.758	74.796	73.835
76.00	3.00	74.740	73.759	73.803	76.090	74.051	74.119	74.163	72.752
76.00	4.00	74.300	72.997	73.047	76.100	73.402	73.477	73.527	71.670
76.00	6.00	73.420	71.473	71.533	76.120	72.103	72.193	72.253	69.505
78.00	2.00	77.176	76.518	76.556	78.076	76.701	76.758	76.796	75.835
80.00	1.50	79.393	78.897	78.931	80.068	79.026	79.077	79.111	78.376
80.00	2.00	79.176	78.518	78.556	80.076	78.701	78.758	78.796	77.835
80.00	3.00	78.740	77.759	77.803	80.090	78.051	78.119	78.163	76.752
80.00	4.00	78.300	76.997	77.047	80.100	77.402	77.477	77.527	75.670
80.00	6.00	77.420	75.473	75.533	80.120	76.103	76.193	76.253	73.505
82.00	2.00	81.176	80.518	80.556	82.076	80.701	80.758	80.796	79.835
85.00	2.00	84.176	83.518	83.556	85.076	83.701	83.758	83.796	82.835
85.00	3.00	83.740	82.759	82.803	85.090	83.051	83.119	83.163	81.752
85.00	4.00	83.300	81.997	82.047	85.100	82.402	82.477	82.527	80.670
85.00	6.00	82.420	80.473	80.533	85.120	81.103	81.193	81.253	78.505
90.00	2.00	89.176	88.518	88.556	90.076	88.701	88.758	88.796	87.835
90.00	3.00	88.740	87.759	87.803	90.090	88.051	88.119	88.163	86.752
90.00	4.00	88.300	86.997	87.047	90.100	87.402	87.477	87.527	85.670
90.00	6.00	87.420	85.473	85.533	90.120	86.103	86.193	86.253	83.505
95.00	2.00	94.180	93.521	93.561	95.080	93.701	93.761	93.801	92.835
95.00	3.00	93.744	92.762	92.809	95.094	93.051	93.122	93.169	91.752
95.00	4.00	93.306	92.001	92.054	95.106	92.402	92.481	92.534	90.670
95.00	6.00	92.426	90.477	90.540	95.126	91.103	91.197	91.260	88.505
100.00	2.00	99.180	98.521	98.561	100.080	98.701	98.761	98.801	97.835
100.00	3.00	98.744	97.762	97.809	100.094	98.051	98.122	98.169	96.752
100.00	4.00	98.306	97.001	97.054	100.106	97.402	97.481	97.534	95.670
100.00	6.00	97.426	95.477	95.540	100.126	96.103	96.197	96.260	93.505

Table 11 Dimensions for ISO Metric Fine Pitch Thread Taps of Class 7H
(Clause A-7)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
2.00	0.25	1.911	1.838	1.850	2.024	1.838	1.868	1.880	1.729
2.20	0.25	2.112	2.038	2.050	2.224	2.038	2.068	2.080	1.929
2.50	0.35	2.369	2.264	2.278	2.527	2.273	2.306	2.320	2.121
3.00	0.35	2.871	2.766	2.780	3.028	2.773	2.808	2.822	2.621
3.50	0.35	3.371	3.266	3.280	3.528	3.273	3.308	3.322	3.121
4.00	0.50	3.807	3.655	3.671	4.032	3.675	3.715	3.731	3.459
4.50	0.50	4.307	4.155	4.171	4.532	4.175	4.215	4.231	3.959
5.00	0.50	4.807	4.655	4.671	5.032	4.675	4.715	4.731	4.459
5.50	0.50	5.307	5.155	5.171	5.532	5.175	5.215	5.231	4.959
6.00	0.75	5.705	5.476	5.497	6.042	5.513	5.566	5.587	5.188
7.00	0.75	6.705	6.476	6.497	7.042	6.513	6.566	6.587	6.188
8.00	0.75	7.705	7.476	7.497	8.042	7.513	7.566	7.587	7.188
8.00	1.00	7.597	7.289	7.313	8.047	7.350	7.409	7.433	6.917
9.00	0.75	8.705	8.476	8.497	9.042	8.513	8.566	8.587	8.188
9.00	1.00	8.597	8.289	8.313	9.047	8.350	8.409	8.433	7.917
10.00	0.75	9.705	9.476	9.497	10.042	9.513	9.566	9.587	9.188
10.00	1.00	9.597	9.289	9.313	10.047	9.350	9.409	9.433	8.917
10.00	1.25	9.488	9.101	9.126	10.050	9.188	9.251	9.276	8.647
11.00	0.75	10.705	10.476	10.497	11.042	10.513	10.566	10.587	10.188
11.00	1.00	10.597	10.289	10.313	11.047	10.350	10.409	10.433	9.917
12.00	1.00	11.600	11.293	11.318	12.050	11.350	11.413	11.438	10.917
12.00	1.25	11.493	11.108	11.136	12.056	11.188	11.258	11.286	10.647
12.00	1.50	11.385	10.921	10.951	12.060	11.026	11.101	11.131	10.376
14.00	1.00	13.600	13.293	13.318	14.050	13.350	13.413	13.438	12.917
14.00	1.25	13.493	13.108	13.136	14.056	13.188	13.258	13.286	12.647
14.00	1.50	13.385	12.921	12.951	14.060	13.026	13.101	13.131	12.376
15.00	1.00	14.600	14.293	14.318	15.050	14.350	14.413	14.438	13.917
15.00	1.50	14.385	13.921	13.951	15.060	14.026	14.101	14.131	13.376
16.00	1.00	15.600	15.293	15.318	16.050	15.350	15.413	15.438	14.917
16.00	1.50	15.385	14.921	14.951	16.060	15.026	15.101	15.131	14.376
17.00	1.00	16.600	16.293	16.318	17.050	16.350	16.413	16.438	15.917
17.00	1.50	16.385	15.921	15.951	17.060	16.026	16.101	16.131	15.376
18.00	1.00	17.600	17.293	17.318	18.050	17.350	17.413	17.438	16.917
18.00	1.50	17.385	16.921	16.951	18.060	17.026	17.101	17.131	16.376
18.00	2.00	17.168	16.546	16.580	18.068	16.701	16.786	16.820	15.835
20.00	1.00	19.600	19.293	19.318	20.050	19.350	19.413	19.438	18.917
20.00	1.50	19.385	18.921	18.951	20.060	19.026	19.101	19.131	18.376
20.00	2.00	19.168	18.546	18.580	20.068	18.701	18.786	18.820	17.835
22.00	1.00	21.600	21.293	21.318	22.050	21.350	21.413	21.438	20.917
22.00	1.50	21.385	20.921	20.951	22.060	21.026	21.101	21.131	20.376
22.00	2.00	21.168	20.546	20.580	22.068	20.701	20.786	20.820	19.835
24.00	1.00	23.603	23.296	23.323	24.053	23.350	23.416	23.443	22.917
24.00	1.50	23.389	22.926	22.958	24.064	23.026	23.106	23.138	22.376
24.00	2.00	23.172	22.551	22.587	24.072	22.701	22.791	22.827	21.835
25.00	1.00	24.603	24.296	24.323	25.053	24.350	24.416	24.443	23.917

Table 11 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	$d_{1B}Max$
25.00	1.50	24.389	23.926	23.958	25.064	24.026	24.106	24.138	23.376
25.00	2.00	24.172	23.551	23.587	25.072	23.701	23.791	23.827	22.835
26.00	1.50	25.389	24.926	24.958	26.064	25.026	25.106	25.138	24.376
27.00	1.00	26.603	26.296	26.323	27.053	26.350	26.416	26.443	25.917
27.00	1.50	26.389	25.926	25.958	27.064	26.026	26.106	26.138	25.376
27.00	2.00	26.172	25.551	25.587	27.072	25.701	25.791	25.827	24.835
28.00	1.00	27.603	27.296	27.323	28.053	27.350	27.416	27.443	26.917
28.00	1.50	27.389	26.926	26.958	28.064	27.026	27.106	27.138	26.376
28.00	2.00	27.172	26.551	26.587	28.072	26.701	26.791	26.827	25.835
30.00	1.00	29.603	29.296	29.323	30.053	29.350	29.416	29.443	28.917
30.00	1.50	29.389	28.926	28.958	30.064	29.026	29.106	29.138	28.376
30.00	2.00	29.172	28.551	28.587	30.072	28.701	28.791	28.827	27.835
30.00	3.00	28.735	27.797	27.840	30.085	28.051	28.157	28.200	26.752
32.00	1.50	31.389	30.926	30.958	32.064	31.026	31.106	31.138	30.376
32.00	2.00	31.172	30.551	30.587	32.072	30.701	30.791	30.827	29.835
33.00	1.50	32.389	31.926	31.958	33.064	32.026	32.106	32.138	31.376
33.00	2.00	32.172	31.551	31.587	33.072	31.701	31.791	31.827	30.835
33.00	3.00	31.735	30.797	30.840	33.085	31.051	31.157	31.200	29.752
35.00	1.50	34.389	33.926	33.958	35.064	34.026	34.106	34.138	33.376
36.00	1.50	35.389	34.926	34.958	36.064	35.026	35.106	35.138	34.376
36.00	2.00	35.172	34.551	34.587	36.072	34.701	34.791	34.827	33.835
36.00	3.00	34.735	33.797	33.840	36.085	34.051	34.157	34.200	32.752
38.00	1.50	37.389	36.926	36.958	38.064	37.026	37.106	37.138	36.376
39.00	1.50	38.389	37.926	37.958	39.064	38.026	38.106	38.138	37.376
39.00	2.00	38.172	37.551	37.587	39.072	37.701	37.791	37.827	36.835
39.00	3.00	37.735	36.797	36.840	39.085	37.051	37.157	37.200	35.752
40.00	1.50	39.389	38.926	38.958	40.064	39.026	39.106	39.138	38.376
40.00	2.00	39.172	38.551	38.587	40.072	38.701	38.791	38.827	37.835
40.00	3.00	38.735	37.797	37.840	40.085	38.051	38.157	38.200	36.752
42.00	1.50	41.389	40.926	40.958	42.064	41.026	41.106	41.138	40.376
42.00	2.00	41.172	40.551	40.587	42.072	40.701	40.791	40.827	39.835
42.00	3.00	40.735	39.797	39.840	42.085	40.051	40.157	40.200	38.752
42.00	4.00	40.294	39.040	39.087	42.094	39.402	39.520	39.567	37.670
45.00	1.50	44.389	43.926	43.958	45.064	44.026	44.106	44.138	43.376
45.00	2.00	44.172	43.551	43.587	45.072	43.701	43.791	43.827	42.835
45.00	3.00	43.735	42.797	42.840	45.085	43.051	43.157	43.200	41.752
45.00	4.00	43.294	42.040	42.087	45.094	42.402	42.520	42.567	40.670
48.00	1.50	47.393	46.931	46.965	48.068	47.026	47.111	47.145	46.376
48.00	2.00	47.176	46.556	46.594	48.076	46.701	46.796	46.834	45.835
48.00	3.00	46.740	45.803	45.848	48.090	46.051	46.163	46.208	44.752
48.00	4.00	46.300	45.047	45.097	48.100	45.402	45.527	45.577	43.670
50.00	1.50	49.393	48.931	48.965	50.068	49.026	49.111	49.145	48.376
50.00	2.00	49.176	48.556	48.594	50.076	48.701	48.796	48.834	47.835
50.00	3.00	48.740	47.803	47.848	50.090	48.051	48.163	48.208	46.752
52.00	1.50	51.393	50.931	50.965	52.068	51.026	51.111	51.145	50.376

Table 11 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
52.00	2.00	51.176	50.556	50.594	52.076	50.701	50.796	50.834	49.835
52.00	3.00	50.740	49.803	49.848	52.090	50.051	50.163	50.208	48.752
52.00	4.00	50.300	49.047	49.097	52.100	49.402	49.527	49.577	47.670
55.00	1.50	54.393	53.931	53.965	55.068	54.026	54.111	54.145	53.376
55.00	2.00	54.176	53.556	53.594	55.076	53.701	53.796	53.834	52.835
55.00	3.00	53.740	52.803	52.848	55.090	53.051	53.163	53.208	51.752
55.00	4.00	53.300	52.047	52.097	55.100	52.402	52.527	52.577	50.670
56.00	1.50	55.393	54.931	54.965	56.068	55.026	55.111	55.145	54.376
56.00	2.00	55.176	54.556	54.594	56.076	54.701	54.796	54.834	53.835
56.00	3.00	54.740	53.803	53.848	56.090	54.051	54.163	54.208	52.752
56.00	4.00	54.300	53.047	53.097	56.100	53.402	53.527	53.577	51.670
58.00	1.50	57.393	56.931	56.965	58.068	57.026	57.111	57.145	56.376
58.00	2.00	57.176	56.556	56.594	58.076	56.701	56.796	56.834	55.835
58.00	3.00	56.740	55.803	55.848	58.090	56.051	56.163	56.208	54.752
58.00	4.00	56.300	55.047	55.097	58.100	55.402	55.527	55.577	53.670
60.00	1.50	59.393	58.931	58.965	60.068	59.026	59.111	59.145	58.376
60.00	2.00	59.176	58.556	58.594	60.076	58.701	58.796	58.834	57.835
60.00	3.00	58.740	57.803	57.848	60.090	58.051	58.163	58.208	56.752
60.00	4.00	58.300	57.047	57.097	60.100	57.402	57.527	57.577	55.670
62.00	1.50	61.393	60.931	60.965	62.068	61.026	61.111	61.145	60.376
62.00	2.00	61.176	60.556	60.594	62.076	60.701	60.796	60.834	59.835
62.00	3.00	60.740	59.803	59.848	62.090	60.051	60.163	60.208	58.752
62.00	4.00	60.300	59.047	59.097	62.100	59.402	59.527	59.577	57.670
64.00	1.50	63.393	62.931	62.965	64.068	63.026	63.111	63.145	62.376
64.00	2.00	63.176	62.556	62.594	64.076	62.701	62.796	62.834	61.835
64.00	3.00	62.740	61.803	61.848	64.090	62.051	62.163	62.208	60.752
64.00	4.00	62.300	61.047	61.097	64.100	61.402	61.527	61.577	59.670
65.00	1.50	64.393	63.931	63.965	65.068	64.026	64.111	64.145	63.376
65.00	2.00	64.176	63.556	63.594	65.076	63.701	63.796	63.834	62.835
65.00	3.00	63.740	62.803	62.848	65.090	63.051	63.163	63.208	61.752
65.00	4.00	63.300	62.047	62.097	65.100	62.402	62.527	62.577	60.670
68.00	1.50	67.393	66.931	66.965	68.068	67.026	67.111	67.145	66.376
68.00	2.00	67.176	66.556	66.594	68.076	66.701	66.796	66.834	65.835
68.00	3.00	66.740	65.803	65.848	68.090	66.051	66.163	66.208	64.752
68.00	4.00	66.300	65.047	65.097	68.100	65.402	65.527	65.577	63.670
70.00	1.50	69.393	68.931	68.965	70.068	69.026	69.111	69.145	68.376
70.00	2.00	69.176	68.556	68.594	70.076	68.701	68.796	68.834	67.835
70.00	3.00	68.740	67.803	67.848	70.090	68.051	68.163	68.208	66.752
70.00	4.00	68.300	67.047	67.097	70.100	67.402	67.527	67.577	65.670
70.00	6.00	67.420	65.533	65.593	70.120	66.103	66.253	66.313	63.505
72.00	1.50	71.393	70.931	70.965	72.068	71.026	71.111	71.145	70.376
72.00	2.00	71.176	70.556	70.594	72.076	70.701	70.796	70.834	69.835
72.00	3.00	70.740	69.803	69.848	72.090	70.051	70.163	70.208	68.752
72.00	4.00	70.300	69.047	69.097	72.100	69.402	69.527	69.577	67.670
72.00	6.00	69.420	67.533	67.593	72.120	68.103	68.253	68.313	65.505

Table 11 (Concluded)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	d_{1BMax}
75.00	1.50	74.393	73.931	73.965	75.068	74.026	74.111	74.145	73.376
75.00	2.00	74.176	73.556	73.594	75.076	73.701	73.796	73.834	72.835
75.00	3.00	73.740	72.803	72.848	75.090	73.051	73.163	73.208	71.752
75.00	4.00	73.300	72.047	72.097	75.100	72.402	72.527	72.577	70.670
76.00	1.50	75.393	74.931	74.965	76.068	75.026	75.111	75.145	74.376
76.00	2.00	75.176	74.556	74.594	76.076	74.701	74.796	74.834	73.835
76.00	3.00	74.740	73.803	73.848	76.090	74.051	74.163	74.208	72.752
76.00	4.00	74.300	73.047	73.097	76.100	73.402	73.527	73.577	71.670
76.00	6.00	73.420	71.533	71.593	76.120	72.103	72.253	72.313	69.505
78.00	2.00	77.176	76.556	76.594	78.076	76.701	76.796	76.834	75.835
80.00	1.50	79.393	78.931	78.965	80.068	79.026	79.111	79.145	78.376
80.00	2.00	79.176	78.556	78.594	80.076	78.701	78.796	78.834	77.835
80.00	3.00	78.740	77.803	77.848	80.090	78.051	78.163	78.208	76.752
80.00	4.00	78.300	77.047	77.097	80.100	77.402	77.527	77.577	75.670
80.00	6.00	77.420	75.533	75.593	80.120	76.103	76.253	76.313	73.505
82.00	2.00	81.176	80.556	80.594	82.076	80.701	80.796	80.834	79.835
85.00	2.00	84.176	83.556	83.594	85.076	83.701	83.796	83.834	82.835
85.00	3.00	83.740	82.803	82.848	85.090	83.051	83.163	83.208	81.752
85.00	4.00	83.300	82.047	82.097	85.100	82.402	82.527	82.577	80.670
85.00	6.00	82.420	80.533	80.593	85.120	81.103	81.253	81.313	78.505
90.00	2.00	89.176	88.556	88.594	90.076	88.701	88.796	88.834	87.835
90.00	3.00	88.740	87.803	87.848	90.090	88.051	88.163	88.208	86.752
90.00	4.00	88.300	87.047	87.097	90.100	87.402	87.527	87.577	85.670
90.00	6.00	87.420	85.533	85.593	90.120	86.103	86.253	86.313	83.505
95.00	2.00	94.180	93.561	93.601	95.080	93.701	93.801	93.841	92.835
95.00	3.00	93.744	92.809	92.857	95.094	93.051	93.169	93.217	91.752
95.00	4.00	93.306	92.054	92.107	95.106	92.402	92.534	92.587	90.670
95.00	6.00	92.426	90.540	90.603	95.126	91.103	91.260	91.323	88.505
100.00	2.00	99.180	98.561	98.601	100.080	98.701	98.801	98.841	97.835
100.00	3.00	98.744	97.809	97.857	100.094	98.051	98.169	98.217	96.752
100.00	4.00	98.306	97.054	97.107	100.106	97.402	97.534	97.587	95.670
100.00	6.00	97.426	95.540	95.603	100.126	96.103	96.260	96.323	93.505

IS 6173 (Part 1) : 1992

Table 12 Dimensions for ISO Metric Fine Pitch Thread Taps of Class 7H Cut
(Clause A-8)

All dimensions in millimetres.

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
2.00	0.25	1.911	1.820	1.844	2.024	1.838	1.850	1.874	1.729
2.20	0.25	2.112	2.020	2.044	2.224	2.038	2.050	2.074	1.929
2.50	0.35	2.369	2.244	2.271	2.527	2.273	2.286	2.313	2.121
3.00	0.35	2.871	2.745	2.773	3.028	2.773	2.787	2.815	2.621
3.50	0.35	3.371	3.245	3.273	3.528	3.273	3.287	3.315	3.121
4.00	0.50	3.807	3.631	3.663	4.032	3.675	3.691	3.723	3.459
4.50	0.50	4.307	4.131	4.163	4.532	4.175	4.191	4.223	3.959
5.00	0.50	4.807	4.631	4.663	5.032	4.675	4.691	4.723	4.459
5.50	0.50	5.307	5.131	5.163	5.532	5.175	5.191	5.223	4.959
6.00	0.75	5.705	5.444	5.486	6.042	5.513	5.534	5.576	5.188
7.00	0.75	6.705	6.444	6.486	7.042	6.513	6.534	6.576	6.188
8.00	0.75	7.705	7.444	7.486	8.042	7.513	7.534	7.576	7.188
8.00	1.00	7.597	7.254	7.301	8.047	7.350	7.374	7.421	6.917
9.00	0.75	8.705	8.444	8.486	9.042	8.513	8.534	8.576	8.188
9.00	1.00	8.597	8.254	8.301	9.047	8.350	8.374	8.421	7.917
10.00	0.75	9.705	9.444	9.486	10.042	9.513	9.534	9.576	9.188
10.00	1.00	9.597	9.254	9.301	10.047	9.350	9.374	9.421	8.917
10.00	1.25	9.488	9.063	9.113	10.050	9.188	9.213	9.263	8.647
11.00	0.75	10.705	10.444	10.486	11.042	10.513	10.534	10.576	10.188
11.00	1.00	10.597	10.254	10.301	11.047	10.350	10.374	10.421	9.917
12.00	1.00	11.600	11.255	11.305	12.050	11.350	11.375	11.425	10.917
12.00	1.25	11.493	11.066	11.122	12.056	11.188	11.216	11.272	10.647
12.00	1.50	11.385	10.876	10.936	12.060	11.026	11.056	11.116	10.376
14.00	1.00	13.600	13.255	13.305	14.050	13.350	13.375	13.425	12.917
14.00	1.25	13.493	13.066	13.122	14.056	13.188	13.216	13.272	12.647
14.00	1.50	13.385	12.876	12.936	14.060	13.026	13.056	13.116	12.376
15.00	1.00	14.600	14.255	14.305	15.050	14.350	14.375	14.425	13.917
15.00	1.50	14.385	13.876	13.936	15.060	14.026	14.056	14.116	13.376
16.00	1.00	15.600	15.255	15.305	16.050	15.350	15.375	15.425	14.917
16.00	1.50	15.385	14.876	14.936	16.060	15.026	15.056	15.116	14.376
17.00	1.00	16.600	16.255	16.305	17.050	16.350	16.375	16.425	15.917
17.00	1.50	16.385	15.876	15.936	17.060	16.026	16.056	16.116	15.376
18.00	1.00	17.600	17.255	17.305	18.050	17.350	17.375	17.425	16.917
18.00	1.50	17.385	16.876	16.936	18.060	17.026	17.056	17.116	16.376
18.00	2.00	17.168	16.495	16.563	18.068	16.701	16.735	16.803	15.835
20.00	1.00	19.600	19.255	19.305	20.050	19.350	19.375	19.425	18.917
20.00	1.50	19.385	18.876	18.936	20.060	19.026	19.056	19.116	18.376
20.00	2.00	19.168	18.495	18.563	20.068	18.701	18.735	18.803	17.835
22.00	1.00	21.600	21.255	21.305	22.050	21.350	21.375	21.425	20.917
22.00	1.50	21.385	20.876	20.936	22.060	21.026	21.056	21.116	20.376
22.00	2.00	21.168	20.495	20.563	22.068	20.701	20.735	20.803	19.835
24.00	1.00	23.603	23.257	23.310	24.053	23.350	23.377	23.430	22.917
24.00	1.50	23.389	22.878	22.942	24.064	23.026	23.058	23.122	22.376
24.00	2.00	23.172	22.497	22.569	24.072	22.701	22.737	22.809	21.835
25.00	1.00	24.603	24.257	24.310	25.053	24.350	24.377	24.430	23.917

Table 12 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	d_{2BNOM}	d_{2BMin}	d_{2BMax}	d_{1BMax}
25.00	1.50	24.389	23.878	23.942	25.064	24.026	24.058	24.122	23.376
25.00	2.00	24.172	23.497	23.569	25.072	23.701	23.737	23.809	22.835
26.00	1.50	25.389	24.878	24.942	26.064	25.026	25.058	25.122	24.376
27.00	1.00	26.603	26.257	26.310	27.053	26.350	26.377	26.430	25.917
27.00	1.50	26.389	25.878	25.942	27.064	26.026	26.058	26.122	25.376
27.00	2.00	26.172	25.497	25.569	27.072	25.701	25.737	25.809	24.835
28.00	1.00	27.603	27.257	27.310	28.053	27.350	27.377	27.430	26.917
28.00	1.50	27.389	26.878	26.942	28.064	27.026	27.058	27.122	26.376
28.00	2.00	27.172	26.497	25.569	28.072	26.701	26.737	26.809	25.835
30.00	1.00	29.603	29.257	29.310	30.053	29.350	29.377	29.430	28.917
30.00	1.50	29.389	28.878	28.942	30.064	29.026	29.058	29.122	28.376
30.00	2.00	29.172	28.497	28.569	30.072	28.701	28.737	28.809	27.835
30.00	3.00	28.735	27.734	27.819	30.085	28.051	28.094	28.179	26.752
32.00	1.50	31.389	30.878	30.942	32.064	31.026	31.058	31.122	30.376
32.00	2.00	31.172	30.497	30.569	32.072	30.701	30.737	30.809	29.835
33.00	1.50	32.389	31.878	31.942	33.064	32.026	32.058	32.122	31.376
33.00	2.00	32.172	31.497	31.569	33.072	31.701	31.737	31.809	30.835
33.00	3.00	31.735	30.734	30.819	33.085	31.051	31.094	31.179	29.752
35.00	1.50	34.389	33.878	33.942	35.064	34.026	34.058	34.122	33.376
36.00	1.50	35.389	34.878	34.942	36.064	35.026	35.058	35.122	34.376
36.00	2.00	35.172	34.497	34.569	36.072	34.701	34.737	34.809	33.835
36.00	3.00	34.735	33.734	33.819	36.085	34.051	34.094	34.179	32.752
38.00	1.50	37.389	36.878	36.942	38.064	37.026	37.058	37.122	36.376
39.00	1.50	38.389	37.878	37.942	39.064	38.026	38.058	38.122	37.376
39.00	2.00	38.172	37.497	37.569	39.072	37.701	37.737	37.809	36.835
39.00	3.00	37.735	36.734	36.819	39.085	37.051	37.094	37.179	35.752
40.00	1.50	39.389	38.878	38.942	40.064	39.026	39.058	39.122	38.376
40.00	2.00	39.172	38.497	38.569	40.072	38.701	38.737	38.809	37.835
40.00	3.00	38.735	37.734	37.819	40.085	38.051	38.094	38.179	36.752
42.00	1.50	41.389	40.878	40.942	42.064	41.026	41.058	41.122	40.376
42.00	2.00	41.172	40.497	40.569	42.072	40.701	40.737	40.809	39.835
42.00	3.00	40.735	39.734	39.819	42.085	40.051	40.094	40.179	38.752
42.00	4.00	40.294	38.969	39.064	42.094	39.402	39.449	39.544	37.670
45.00	1.50	44.389	43.878	43.942	45.064	44.026	44.058	44.122	43.376
45.00	2.00	44.172	43.497	43.569	45.072	43.701	43.737	43.809	42.835
45.00	3.00	43.735	42.734	42.819	45.085	43.051	43.094	43.179	41.752
45.00	4.00	43.294	41.969	42.064	45.094	42.402	42.449	42.544	40.670
48.00	1.50	47.393	46.880	46.948	48.068	47.026	47.060	47.128	46.376
48.00	2.00	47.176	46.499	46.575	48.076	46.701	46.739	46.815	45.835
48.00	3.00	46.740	45.736	45.826	48.090	46.051	46.096	46.186	44.752
48.00	4.00	46.300	44.972	45.072	48.100	45.402	45.452	45.552	43.670
50.00	1.50	49.393	48.880	48.948	50.068	49.026	49.060	49.128	48.376
50.00	2.00	49.176	48.499	48.575	50.076	48.701	48.739	48.815	47.835
50.00	3.00	48.740	47.736	47.826	50.090	48.051	48.096	48.186	46.752
52.00	1.50	51.393	50.880	50.948	52.068	51.026	51.060	51.128	50.376

Table 12 (Continued)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	d_{1BMax}
52.00	2.00	51.176	50.499	50.575	52.076	50.701	50.739	50.815	49.835
52.00	3.00	50.740	49.736	49.826	52.090	50.051	50.096	50.186	48.752
52.00	4.00	50.300	48.972	49.072	52.100	49.402	49.452	49.552	47.670
55.00	1.50	54.393	53.880	53.948	55.068	54.026	54.060	54.128	53.376
55.00	2.00	54.176	53.499	53.575	55.076	53.701	53.739	53.815	52.835
55.00	3.00	53.740	52.736	52.826	55.090	53.051	53.096	53.186	51.752
55.00	4.00	53.300	51.972	52.072	55.100	52.402	52.452	52.552	50.670
56.00	1.50	55.393	54.880	54.948	56.068	55.026	55.060	55.128	54.376
56.00	2.00	55.176	54.499	54.575	56.076	54.701	54.739	54.815	53.835
56.00	3.00	54.740	53.736	53.826	56.090	54.051	54.096	54.186	52.752
56.00	4.00	54.300	52.972	53.072	56.100	53.402	53.452	53.552	51.670
58.00	1.50	57.393	56.880	56.948	58.068	57.026	57.060	57.128	56.376
58.00	2.00	57.176	56.499	56.575	58.076	56.701	56.739	56.815	55.835
58.00	3.00	56.740	55.736	55.826	58.090	56.051	56.096	56.186	54.752
58.00	4.00	56.300	54.972	55.072	58.100	55.402	55.452	55.552	53.670
60.00	1.50	59.393	58.880	58.948	60.068	59.026	59.060	59.128	58.376
60.00	2.00	59.176	58.499	58.575	60.076	58.701	58.739	58.815	57.835
60.00	3.00	58.740	57.736	57.826	60.090	58.051	58.096	58.186	56.752
60.00	4.00	58.300	56.972	57.072	60.100	57.402	57.452	57.552	55.670
62.00	1.50	61.393	60.880	60.948	62.068	61.026	61.060	61.128	60.376
62.00	2.00	61.176	60.499	60.575	62.076	60.701	60.739	60.815	59.835
62.00	3.00	60.740	59.736	59.826	62.090	60.051	60.096	60.186	58.752
62.00	4.00	60.300	58.972	59.072	62.100	59.402	59.452	59.552	57.670
64.00	1.50	63.393	62.880	62.948	64.068	63.026	63.060	63.128	62.376
64.00	2.00	63.176	62.499	62.575	64.076	62.701	62.739	62.815	61.835
64.00	3.00	62.740	61.736	61.826	64.090	62.051	62.096	62.186	60.752
64.00	4.00	62.300	60.972	61.072	64.100	61.402	61.452	61.552	59.670
65.00	1.50	64.393	63.880	63.948	65.068	64.026	64.060	64.128	63.376
65.00	2.00	64.176	63.499	63.575	65.076	63.701	63.739	63.815	62.835
65.00	3.00	63.740	62.736	62.826	65.090	63.051	63.096	63.186	61.752
65.00	4.00	63.300	61.972	62.072	65.100	62.402	62.452	62.552	60.670
68.00	1.50	67.393	66.880	66.948	68.068	67.026	67.060	67.128	66.376
68.00	2.00	67.176	66.499	66.575	68.076	66.701	66.739	66.815	65.835
68.00	3.00	66.740	65.736	65.826	68.090	66.051	66.096	66.186	64.752
68.00	4.00	66.300	64.972	65.072	68.100	65.402	65.452	65.552	63.670
70.00	1.50	69.393	68.880	68.948	70.068	69.026	69.060	69.128	68.376
70.00	2.00	69.176	68.499	68.575	70.076	68.701	68.739	68.815	67.835
70.00	3.00	68.740	67.736	67.826	70.090	68.051	68.096	68.186	66.752
70.00	4.00	68.300	66.972	67.072	70.100	67.402	67.452	67.552	65.670
70.00	6.00	67.420	65.443	65.563	70.120	66.103	66.163	66.283	63.505
72.00	1.50	71.393	70.880	70.948	72.068	71.026	71.060	71.128	70.376
72.00	2.00	71.176	70.499	70.575	72.076	70.701	70.739	70.815	69.835
72.00	3.00	70.740	69.736	69.826	72.090	70.051	70.096	70.186	68.752
72.00	4.00	70.300	68.972	69.072	72.100	69.402	69.452	69.552	67.670
72.00	6.00	69.420	67.443	67.563	72.120	68.103	68.163	68.283	65.505

Table 12 (Concluded)

Nominal Dia	Pitch	Rougher			Finisher				
		d_{BMin}	d_{2BMin}	d_{2BMax}	d_{BMin}	$d_{2B}NOM$	d_{2BMin}	d_{2BMax}	d_{1BMax}
75.00	1.50	74.393	73.880	73.948	75.068	74.026	74.060	74.128	73.376
75.00	2.00	74.176	73.499	73.575	75.076	73.701	73.739	73.815	72.835
75.00	3.00	73.740	72.736	72.826	75.090	73.051	73.096	73.186	71.752
75.00	4.00	73.300	71.972	72.072	75.100	72.402	72.452	72.552	70.670
76.00	1.50	75.393	74.880	74.948	76.068	75.026	75.060	75.128	74.376
76.00	2.00	75.176	74.499	74.575	76.076	74.701	74.739	74.815	73.835
76.00	3.00	74.740	73.736	73.826	76.090	74.051	74.096	74.186	72.752
76.00	4.00	74.300	72.972	73.072	76.100	73.402	73.452	73.552	71.670
76.00	6.00	73.420	71.443	71.563	76.120	72.103	72.163	72.283	69.505
78.00	2.00	77.176	76.499	76.575	78.076	76.701	76.739	76.815	75.835
80.00	1.50	79.393	78.880	78.948	80.068	79.026	79.060	79.128	78.376
80.00	2.00	79.176	78.499	78.575	80.076	78.701	78.739	78.815	77.835
80.00	3.00	78.740	77.736	77.826	80.090	78.051	78.096	78.186	76.752
80.00	4.00	78.300	76.972	77.072	80.100	77.402	77.452	77.552	75.670
80.00	6.00	77.420	75.443	75.563	80.120	76.103	76.163	76.283	73.505
82.00	2.00	81.176	80.499	80.575	82.076	80.701	80.739	80.815	79.835
85.00	2.00	84.176	83.499	83.575	85.076	83.701	83.739	83.815	82.835
85.00	3.00	83.740	82.736	82.826	85.090	83.051	83.096	83.186	81.752
85.00	4.00	83.300	81.972	82.072	85.100	82.402	82.452	82.552	80.670
85.00	6.00	82.420	80.443	80.563	85.120	81.103	81.163	81.283	78.505
90.00	2.00	89.176	88.499	88.575	90.076	88.701	88.739	88.815	87.835
90.00	3.00	88.740	87.736	87.826	90.090	88.051	88.096	88.186	86.752
90.00	4.00	88.300	86.972	87.072	90.100	87.402	87.452	87.552	85.670
90.00	6.00	87.420	85.443	85.563	90.120	86.103	86.163	86.283	83.505
95.00	2.00	94.180	93.501	93.581	95.080	93.701	93.741	93.821	92.835
95.00	3.00	93.744	92.739	92.833	95.094	93.051	93.099	93.193	91.752
95.00	4.00	93.306	91.975	92.081	95.106	92.402	92.455	92.561	90.670
95.00	6.00	92.426	90.446	90.572	95.126	91.103	91.166	91.292	88.505
100.00	2.00	99.180	98.501	98.581	100.080	98.701	98.741	98.821	97.835
100.00	3.00	98.744	97.739	97.833	100.094	98.051	98.099	98.193	96.752
100.00	4.00	98.306	96.975	97.081	100.106	97.402	97.455	97.561	95.670
100.00	6.00	97.426	95.446	95.572	100.126	96.103	96.166	96.292	93.505

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